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SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES



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DEPARTMENT OF DEFENSE
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SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

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FOREWORD

This publication provides sampling procedures and reference tables for use in planning and conducting inspection by attributes. The sampling concept is based on the probabilistic recurrence of events when a series of lots or batches are produced in a stable environment.

This publication should be used to guide the user in the development of an inspection strategy that provides a cost effective approach to attaining confidence in product compliance with contractual technical requirements. The user is warned of the assumed risks relative to the chosen sample size and AQL.

Military specifications should not contain requirements for use of specific sampling plans, nor should they provide AQL's or LTPD's as a requirement.

Sampling plans for continuous, rather than lot inspection, are contained in MIL-STD-1235, "Single and Multi-Level Continuous Sampling Procedures and Tables for Inspection by Attributes".

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SAMPLING PROCEDURES AND TABLES
FOR INSPECTION BY ATTRIBUTES

1. SCOPE

1.1 Purpose. This publication establishes lot or batch sampling plans and procedures for inspection by attributes. This publication shall not be interpreted to supercede or conflict with any contractual requirements. The words "accept", "acceptance", "acceptable", etc, refer only to the contractor's use of the sampling plans contained in this standard and do not imply an agreement by the Government to accept any product. Determination of acceptability by the Government shall be as described in contractual documents. The sampling plans described in this standard are applicable to AQL's of .01 percent or higher and are therefore not suitable for applications where quality levels in the defective parts per million range can be realized.

1.2 Application. Sampling plans designated in this publication are applicable, but not limited, to inspection of the following:

- a. End items.
- b. Components and raw materials.
- c. Operations or services.
- d. Materials in process.
- e. Supplies in storage.
- f. Maintenance operations.
- g. Data or records.
- h. Administrative procedures.

These plans are intended primarily to be used for a continuing series of lots or batches. The plans may also be used for the inspection of isolated lots or batches, but, in this latter case, the user is cautioned to consult the operating characteristic curves to find a plan which will yield the desired protection (See 4.11).

2. REFERENCED DOCUMENTS

2.1 Not applicable.

3. DEFINITIONS

3.1 Acceptable Quality Level (AQL). When a continuous series of lots is considered, the AQL is the quality level which, for the purposes of sampling inspection, is the limit of a satisfactory process average (See 3.19).

NOTE: A sampling plan and an AQL are chosen in accordance with the risk assumed. Use of a value of AQL for a certain defect or group of defects indicates that the sampling plan will accept the great majority of the lots or batches provided the process average level of percent defective (or defects per hundred units) in these lots or batches be no greater than the designated value of AQL. Thus, the AQL is a designated value of percent defective (or defects per hundred units) for which lots will be accepted most of the time by the sampling procedure being used. The sampling plans provided herein are so arranged that the probability of acceptance at the designated AQL value depends upon the sample size, being generally higher for large samples than for small ones, for a given AQL. The AQL alone does not identify the chances of accepting or rejecting individual lots or batches but more directly relates to what might be expected from a series of lots or batches, provided the steps indicated in this publication are taken. It is necessary to refer to the operating characteristic curve of the plan to determine the relative risks.

3.2 Average Outgoing Quality (AOQ). For a particular process average, the AOQ is the average quality of outgoing product including all accepted lots or batches, plus all rejected lots or batches after the rejected lots or batches have been effectively 100 percent inspected and all defectives replaced by non-defectives.

3.3 Average Outgoing Quality Limit (AOQL). The AOQL is the maximum AOQ for a given acceptance sampling plan. Factors for computing AOQL values are given in Table V-A for each of the single sampling plans for normal inspection and in Table V-B for each of the single sampling plans for tightened inspection.

3.4 Classification of Defects. A classification of defects is the enumeration of possible defects of the unit of product classified according to their seriousness.

3.5 Critical Defect. A critical defect is a defect that judgement and experience indicate would result in hazardous or unsafe conditions for individuals using, maintaining, or depending upon the product, or a defect that judgement and experience indicate is likely to prevent performance of the tactical function of a major end item such as a ship, aircraft, tank, missile, or space vehicle.

3.6 Critical Defective. A critical defective is a unit of product which contains one or more critical defects and may also contain major and/or minor defects.

3.7 Defect. A defect is any nonconformance of the unit of product with specified requirements.

3.8 Defective. A defective is a unit of product which contains one or more defects.

3.9 Defects per Hundred Units. The number of defects per hundred units of any given quantity of units of product is one hundred times the number of defects contained therein (one or more defects being possible in any unit of product) divided by the total number of units of product, i.e.:

$$\begin{array}{lcl} \text{Defects per} & = & \frac{\text{Number of defects} \times 100}{\text{Number of units inspected}} \\ \text{hundred units} & & \end{array}$$

3.10 Inspection. Inspection is the process of measuring, examining, testing, or otherwise comparing the unit of product with the requirements.

3.11 Inspection by Attributes. Inspection by attributes is inspection whereby either the unit of product is classified simply as defective or non-defective, or the number of defects in the unit of product is counted, with respect to a given requirement or set of requirements.

3.12 Lot or Batch. The term lot or batch shall mean "inspection lot" or "inspection batch", i.e., a collection of units of product from which a sample is to be drawn and inspected and may differ from a collection of units designated as a lot or batch for other purposes (e.g., production, shipment, etc.).

3.13 Lot or Batch Size. The lot or batch size is the number of units of product in a lot or batch.

3.14 Major Defect. A major defect is a defect, other than critical, that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose.

3.15 Major Defective. A major defective is a unit of product which contains one or more major defects, and may also contain minor defects but contains no critical defect.

3.16 Minor Defect. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.

3.17 Minor Defective. A minor defective is a unit of product which contains one or more minor defects but contains no critical or major defect.

3.18 Percent Defective. The percent defective of any given quantity of units of product is one hundred times the number of defective units of product contained therein divided by the total number of units of product, i.e.:

$$\text{Percent Defective} = \frac{\text{Number of defectives} \times 100}{\text{Number of units inspected}}$$

3.19 Process Average. The process average is the average percent defective or average number of defects per hundred units (whichever is applicable) of product submitted by the supplier for original inspection. Original inspection is the first inspection of a particular quantity of product as distinguished from the inspection of product which has been resubmitted after prior rejection.

3.20 Sample. A sample consists of one or more units of product drawn from a lot or batch, the units of the sample being selected at random without regard to their quality. The number of units of product in the sample is the sample size.

3.21 Sample Size Code Letter. The sample size code letter is a device used along with the AQL for locating a sampling plan on a table of sampling plans.

3.22 Sampling Plan. A sampling plan indicates the number of units of product from each lot or batch which are to be inspected (sample size or series of sample sizes) and the criteria for determining the acceptability of the lot or batch (acceptance and rejection numbers).

3.23 Unit of Product. The unit of product is the thing inspected in order to determine its classification as defective or non-defective or to count the number of defects. It may be a single article, a pair, a set, a length, an area, an operation, a volume, a component of an end product, or the end product itself. The unit of product may or may not be the same as the unit of purchase, supply, production, or shipment.

4. GENERAL REQUIREMENTS

4.1 Written Procedures. Written procedures are ordinarily developed and made available for the Government representative's review, upon request. When the written procedures indicate use of this standard, they shall comply with the requirements of this standard and reference appropriate parts as necessary.

4.2 Nonconformance. The extent of nonconformance of product shall be expressed either in terms of percent defective or in terms of defects per hundred units.

4.3 Formation and Identification of Lots or Batches. The product shall be assembled into identifiable lots, sublots, batches, or in such other manner as may be prescribed. Each lot or batch shall, as far as is practicable, consist of units of product of a single type, grade, class, size, and composition, manufactured under essentially the same conditions, and at essentially the same time. The lots or batches shall be identified by the contractor and shall be kept intact in adequate and suitable storage space.

4.4 AQL.

4.4.1 AQL Use. The AQL, together with the Sample Size Code Letter, is used for indexing the sampling plans provided herein.

4.4.2 Limitation. The selection or use of an AQL shall not imply that the contractor has the right to supply any defective unit of product.

4.4.3 Choosing AQLs. Different AQLs may be chosen for groups of defects considered collectively, or for individual defects. An AQL for a group of defects may be chosen in addition to AQLs for individual defects, or subgroups, within that group. AQL values of 10.0 or less may be expressed either in percent defective or in defects per hundred units; those over 10.0 shall be expressed in defects per hundred units only.

4.5 Sampling.

4.5.1 Representative (Stratified) Sampling. When appropriate, the number of units in the sample shall be selected in proportion to the size of sublots or sub-batches, or parts of the lot or batch, identified by some rational criterion. When representative sampling is used, the units from each subplot, sub-batch or part of the lot or batch shall be selected at random.

4.5.2 Time of Sampling. A sample may be drawn after all the units comprising the lot or batch have been assembled, or sample units may be drawn during assembly of the lot or batch, in which case the size of the lot or batch will be determined before any sample units are drawn. If the sample units are drawn during assembly of the lot or batch, and if the rejection number is reached before the lot is completed, that portion of the lot already completed shall be rejected. The cause of the defective product shall be determined and corrective action taken, after which a new lot or batch shall be begun.

4.5.3 Double or Multiple Sampling. When double or multiple sampling is to be used, each sample shall be selected over the entire lot or batch.

4.6 Inspection Procedures. Normal inspection will be used at the start of inspection. Normal, tightened or reduced inspection shall continue unchanged for each class of defects or defectives on successive lots or batches except where the switching procedures given below require change. The switching procedures shall be applied to each class of defects or defectives independently.

4.7 Switching Procedures.

4.7.1 Normal to Tightened. When normal inspection is in effect, tightened inspection shall be instituted when 2 out of 2, 3, 4, or 5 consecutive lots or batches have been rejected on original inspection (i.e., ignoring resubmitted lots or batches for this procedure).

4.7.2 Tightened to Normal. When tightened inspection is in effect, normal inspection shall be instituted when 5 consecutive lots or batches have been considered acceptable on original inspection.

4.7.3 Normal to Reduced. When normal inspection is in effect, reduced inspection shall be instituted provided that all of the following conditions are satisfied:

a. The preceding 10 lots or batches (or more, as indicated by the note to Table VIII) have been on normal inspection and all have been accepted on original inspection; and

b. The total number of defectives (or defects) in the samples from the preceding 10 lots or batches (or such other number as was used for condition "a" above) is equal to or less than the applicable number given in Table VIII. If double or multiple sampling is in use, all samples inspected should be included, not "first" samples only; and

c. Production is at a steady rate; and

d. Reduced inspection is considered desirable.

4.7.4 Reduced to Normal. When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection:

a. A lot or batch is rejected; or

b. A lot or batch is considered acceptable under the procedures of 4.10.1.4, or

c. Production becomes irregular or delayed; or

d. Other conditions warrant that normal inspection shall be instituted.

4.8 Discontinuation of Inspection. If the cumulative number of lots not accepted in a sequence of consecutive lots on original tightened inspection reaches five, the acceptance procedures of this standard shall be discontinued. Inspection under the provisions of this standard shall not be resumed until corrective action has been taken. Tightened inspection shall then be used as if 4.7.1 had been invoked.

4.9 Sampling Plans.

4.9.1 Inspection Level. The inspection level determines the relationship between the lot or batch size and the sample size. The inspection level to be used for any particular requirement will be as prescribed by the contractor's written procedures. Three inspection levels: I, II, and III, are given in Table I for general use (see 4.1). Normally, Inspection Level II is used. However, Inspection Level I may be used when less discrimination is needed, or Level III may be used for greater discrimination. Four additional special levels: S-1, S-2, S-3, and S-4, are given in the same table and may be used where relatively small sample sizes are necessary and large sampling risks can or must be tolerated.

NOTE: In the selection of inspection levels S-1 to S-4, care must be exercised to avoid AQLs inconsistent with these inspection levels. In other words, the purpose of the special inspection levels is to keep samples small when necessary. For instance, the code letters under S-1 go no further than D, equivalent to a single sample of size 8, but it is of no use to choose S-1 if the AQL is 0.10 percent for which the minimum sample is 125.

4.9.2 Code Letters. Sample sizes are designated by code letters. Table I shall be used to find the applicable code letter for the particular lot or batch size and the prescribed inspection level.

4.9.3 Obtaining Sampling Plan. The AQL and the code letter shall be used to obtain the sampling plan from Tables II, III, or IV. When no sampling plan is available for a given combination of AQL and code letter, the tables direct the user to a different letter. The sample size to be used is given by the new code letter, not by the original letter. If this procedure leads to different sample sizes for different classes of defects, the code letter corresponding to the largest sample size derived may be used for all classes of defects. As an alternative to a single sampling plan with an acceptance number of 0, the plan with an acceptance number of 1 with its correspondingly larger sample size for a designated AQL (where available), may be used.

4.9.4 Types of Sampling Plans. Three types of sampling plans: Single, Double, and Multiple, are given in Tables II, III, and IV, respectively. When several types of plans are available for a given AQL and code letter, any one may be used. A decision as to type of plan, either single, double, or multiple, when available for a given AQL and code letter, will usually be based upon the comparison between the administrative difficulty and the average sample sizes of the available plans. The average sample size of multiple plans is less than for double (except in the case corresponding to single acceptance number 1) and both of these are always less than a single sample size (see Table IX). Usually the administrative difficulty for single sampling and the cost per unit of the sample are less than for double or multiple.

4.10 Determination of Acceptability.

4.10.1 Percent Defective Inspection. To determine acceptability of a lot or batch under percent defective inspection, the applicable sampling plan shall be used in accordance with 4.10.1.1, 4.10.1.2, 4.10.1.3, and 4.10.1.4.

4.10.1.1 Single Sampling Plan. The number of sample units inspected shall be equal to the sample size given by the plan. If the number of defectives found in the sample is equal to or less than the acceptance number, the lot or batch shall be considered acceptable. If the number of defectives is equal to or greater than the rejection number, the lot or batch shall be rejected.

4.10.1.2 Double Sampling Plan. A number of sample units equal to the first sample size given by the plan shall be inspected. If the number of defectives found in the first sample is equal to or less than the first acceptance number, the lot or batch shall be considered acceptable. If the number of defectives found in the first sample is equal to or greater than the first rejection number, the lot or batch shall be rejected. If the number of defectives found in the first sample is between the first acceptance and rejection numbers, a second sample of the same size shall be inspected. The number of defectives found in the first and second samples shall be accumulated. If the cumulative number of defectives is equal to or less than the second acceptance number, the lot or batch shall be considered acceptable. If the cumulative number of defectives is equal to or greater than the second rejection number, the lot or batch shall be rejected.

4.10.1.3 Multiple Sample Plan. Under multiple sampling, the procedure shall be similar to that specified in 4.10.1.2, except that the number of successive samples required to reach a decision may be as many as seven.

4.10.1.4 Special Procedure for Reduced Inspection. Under reduced inspection, the sampling procedure may terminate without either acceptance or rejection criteria having been met. In these circumstances, the lot or batch will be considered acceptable, but normal inspection will be reinstated starting with the next lot or batch (see 4.7.4.b).

4.10.2 Defects per Hundred Units Inspection. To determine the acceptability of a lot or batch under defects per hundred units inspection, the procedure specified for percent defective inspection above shall be used, except that the word "defects" shall be substituted for "defectives".

4.11 Limiting Quality Protection. The sampling plans and associated procedures given in this publication were designed for use where the units of product are produced in a continuing series of lots or batches over a period of time. However, if the lot or batch is of an isolated nature, it is desirable to limit the selection of sampling plans to those, associated with a designated AQL value, that provide not less than a specified limiting quality protection. Sampling plans for this purpose can be selected by choosing a Limiting Quality (LQ) and a consumer's risk to be associated with it. Tables VI and VII give values of LQ for the commonly used consumer's risks of 10 percent and 5 percent respectively. If a different value of consumer's risk is required, the O.C. curves and their tabulated values may be used. The concept of LQ may also be useful in specifying the AQL and Inspection Levels for a series of lots or batches, thus fixing minimum sample size where there is some reason for avoiding (with more than a given consumer's risk) more than a limiting proportion of defectives (or defects) in any single lot or batch.

4.12 Curves.

4.12.1 Operating Characteristic Curves. The operating characteristic curves for normal inspection, shown in Table X, indicate the percentage of lots or batches which may be expected to be accepted under the various sampling plans for a given process quality. The curves shown are for single sampling; curves for double and multiple sampling are matched as closely as practicable. The O.C. curves shown for AQLs greater than 10.0 are based on the Poisson distribution and are applicable for defects per hundred units inspection; those for AQLs of 10.0 or less and sample sizes of 80 or less are based on the binomial distribution and are applicable for percent defective inspection; those for AQLs of 10.0 or less and sample sizes larger than 80 are based the Poisson distribution and are applicable either for defects per hundred units inspection, or for percent defective inspection (the Poisson distribution being an adequate approximation to the binomial distribution under these conditions). Tabulated values, corresponding to selected values or probabilities of acceptance (P_a , in percent) are given for each of the curves shown, and, in addition, for tightened inspection, and for defects per hundred units for AQLs of 10.0 or less and sample sizes of 80 or less.

4.12.2 Average Sample Size Curves. Average sample size curves for double and multiple sampling are in Table IX. These show the average sample sizes which may be expected to occur under the various sampling plans for given levels of process quality. The curves assume no curtailment of inspection and are approximate to the extent that they are based upon the Poisson distribution, and that the sample sizes for double and multiple sampling are assumed to be $0.631n$ and $0.25n$ respectively, where n is the equivalent sample size.

SECTION 5
TABLES AND CURVES

TABLE I—Sa. *See size code letters*

(see 4.9.1 and 4.9.2)

Lot or batch size	Special inspection levels				General inspection levels		
	S-1	S-2	S-3	S-4	I	II	III
2 to 8	A	A	A	A	A	A	B
9 to 15	A	A	A	A	A	B	C
16 to 25	A	A	B	B	B	C	D
26 to 50	A	B	B	C	C	D	E
51 to 90	B	B	C	C	C	E	F
91 to 150	B	B	C	D	D	F	G
151 to 280	B	C	D	E	E	G	H
281 to 500	B	C	D	E	F	H	J
501 to 1200	C	C	E	F	G	J	K
1201 to 3200	C	D	E	G	H	K	L
3201 to 10000	C	D	F	G	J	L	M
10001 to 35000	C	D	F	H	K	M	N
35001 to 150000	D	E	G	J	L	N	P
150001 to 500000	D	E	G	J	M	P	Q
500001 and over	D	E	H	K	N	Q	R

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**SINGLE
NORMAL**

 Use first sampling plan below arrow. If sample size equals, or exceeds, lot or batch size, do 100 percent inspection.
 Use first sampling plan above arrow.
 Ac Acceptance number.
 Re Rejection number.

TABLE II-B—Single sampling plan. r tightened inspection (Master table)

(see 4.9.3 and 4.9.4)

Sample size code letter	Acceptable Quality Levels (tightened inspection)																		Sample size
	0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	
A	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	2
B	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	3
C	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	5
D	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	8
E	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	13
P	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	20
G	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	32
H	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	50
J	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	80
K	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	125
L	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	200
M	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	315
N	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	500
P	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	800
Q	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	1250
R	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	2000
S	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	3150

 Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 Use first sampling plan above arrow.
 Ac = Acceptance number.
 Re = Rejection number.

TABLE II-C—Single sampling plans for reduced inspection (Master table)

(see 4.9.3 and 4.9.4)

Sample size code letter		Sample size	Acceptable Quality Levels (reduced inspection)†																				
			0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000
A	2	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
B	2	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
C	2	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
D	3	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
E	5	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
F	8	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
G	13	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
H	20	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
J	32	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
K	50	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
L	80	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
M	125	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
N	200	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
P	315	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
Q	500	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
R	800	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re

Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.

Use first sampling plan above arrow.

Ac Acceptance number.

Re Rejection number.

† If the acceptance number has been exceeded, but the rejection number has not been exceeded, accept the lot, but reinspect normal inspection (see 4.10.1.4)

Sample code letter	Sample size	Cumulative sample size	Acceptable Quality Levels (normal inspection)																							
			0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000			
			Ac	He	Ac	He	Ac	He	Ac	He	Ac	He	Ac	He	Ac	He	Ac	He	Ac	He	Ac	He	Ac	He		
A			↓																							
B	First Second	2 6	↓																							
C	First Second	3 6	↓																							
D	First Second	5 10	↓																							
E	First Second	8 16	↓																							
F	First Second	13 26	↓																							
G	First Second	20 40	↓																							
H	First Second	32 64	↓																							
J	First Second	50 100	↓																							
K	First Second	80 160	↓																							
L	First Second	125 250	↓																							
M	First Second	200 400	↓																							
N	First Second	315 630	↓																							
P	First Second	500 1000	↓																							
Q	First Second	800 1600	↓																							
R	First Second	1250 2500	↓																							

- ➡ Use first sampling plan below arrow.
- ➡ Use first sampling plan below arrow.
- ➡ Use first sampling plan above arrow.
- Ac Acceptance number
- Re Rejection number
- Use corresponding single sampling plan (or alternatively, use double sampling plan below, where available).

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TABLE III-B—Double sampling plans for tightened inspection (Master table)
(see 4.9.3 and 4.9.4)

Acceptable Quality Levels (tightened inspection)																							
Sample size code letter	Sample size	Common sample size	0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	170	270	400	650	1000
A																							
B	First Second	2 4																					
C	First Second	3 6																					
D	First Second	5 10																					
E	First Second	8 16																					
F	First Second	13 26																					
G	First Second	20 40																					
H	First Second	32 64																					
I	First Second	50 100																					
J	First Second	80 160																					
K	First Second	125 250																					
L	First Second	200 400																					
M	First Second	315 630																					
N	First Second	500 1000																					
O	First Second	800 1600																					
P	First Second	1250 2500																					
Q	First Second	2000 4000																					

→ Use first sampling plan below arrow
 ← Use first sampling plan above arrow
 Ac Acceptance number
 Re Rejection number
 o Use corresponding single sampling plan (or, alternatively, use double sampling plan below, where available)

DOUBLE
TIGHTENED

(see 4.9.3 and 4.9.4)

Acceptable Quality Levels (reduced inspection)†																									
Sample size code letter	Sample size	Cumulative sample value	0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000		
			Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
A			→																						
B			→																						
C			→																						
U	First	2	→																						
	Second	4	→																						
F	First	3	→																						
	Second	6	→																						
P	First	5	→																						
	Second	10	→																						
G	First	8	→																						
	Second	16	→																						
M	First	13	→																						
	Second	26	→																						
J	First	20	→																						
	Second	40	→																						
K	First	32	→																						
	Second	64	→																						
L	First	50	→																						
	Second	100	→																						
H	First	80	→																						
	Second	160	→																						
N	First	125	→																						
	Second	250	→																						
P	First	200	→																						
	Second	400	→																						
U	First	315	→																						
	Second	630	→																						
R	First	500	→																						
	Second	1000	→																						

If the first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.

Use first sampling plan above arrow.

Acceptance number.

Rejection number.

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If, after the second

**DOUBLE
REDUCED**

TABLE IV-A—Multiple sampling plans for normal inspection (Master table)

(see 4.9.3 and 4.9.4)

		Acceptable Quality Levels (normal inspection)																	
		0.010	0.005	0.010	0.015	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.100	0.110	0.120	0.130	0.140	0.150
Sample size code letter	Sample size	Ac Re																Ac Re	
		Ac Re																Ac Re	
A	First	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
	Second	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
	Third	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
	Fourth	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
	Fifth	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
	Sixth	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
	Seventh	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
B	First	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	Second	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	Third	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	Fourth	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	Fifth	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	Sixth	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	Seventh	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
C	First	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
	Second	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
	Third	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
	Fourth	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
	Fifth	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
	Sixth	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
	Seventh	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
D	First	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5
	Second	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5
	Third	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5
	Fourth	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5
	Fifth	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5
	Sixth	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5
	Seventh	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5
E	First	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
	Second	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
	Third	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
	Fourth	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
	Fifth	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
	Sixth	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
	Seventh	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
F	First	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7
	Second	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7
	Third	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7
	Fourth	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7
	Fifth	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7
	Sixth	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7
	Seventh	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7
G	First	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
	Second	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
	Third	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
	Fourth	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
	Fifth	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
	Sixth	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
	Seventh	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
H	First	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9
	Second	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9
	Third	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9
	Fourth	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9
	Fifth	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9
	Sixth	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9
	Seventh	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9
I	First	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10
	Second	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10
	Third	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10
	Fourth	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10
	Fifth	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10
	Sixth	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10
	Seventh	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10

Use first sampling plan below arrow border in continuation of table on following page, when necessary. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 Use first sampling plan above arrow.
 Ac = Acceptance number.
 Re = Rejection number.
 Use corresponding single sampling plan (or alternatively, use multiple sampling plan below, where available).
 Use corresponding double sampling plan (or alternatively, use multiple sampling plan below, where available).
 Acceptance not permitted at this sample size.

MULTIPLE
NORMAL

(see 4.9.3 and 4.9.4)

- ☐ Use first sampling plan below shown. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
- ☐ Use first sampling plan above shown (refer to preceding page, when necessary).
- ☐ Acceptance number.
- ☐ Rejection number.
- ☐ Use corresponding single sampling plan (or alternatively, use multiple plan below, where available).
- ☐ Acceptance not permitted at this sample size.

**MULTIPLE
NORMAL**

TABLE IV-B—Multiple sampling plans for tightened inspection (Master table)

Acceptable Quality Levels (lightened inspection)																							
Sample size	Sample size	Sample size	Acceptable Quality Levels (lightened inspection)																Sample size	Sample size	Sample size		
			0.10	0.075	0.050	0.040	0.025	0.020	0.015	0.010	0.005	0.0025	0.0015	0.0010	0.0005	0.00025	0.00015	0.00010				0.00005	0.000025
I	I	I	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
II	II	II	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
III	III	III	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
IV	IV	IV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
V	V	V	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
VI	VI	VI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
VII	VII	VII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
VIII	VIII	VIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
IX	IX	IX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
X	X	X	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XI	XI	XI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XII	XII	XII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XIII	XIII	XIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XIV	XIV	XIV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XV	XV	XV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XVI	XVI	XVI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XVII	XVII	XVII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XVIII	XVIII	XVIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XIX	XIX	XIX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XX	XX	XX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXI	XXI	XXI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXII	XXII	XXII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXIII	XXIII	XXIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXIV	XXIV	XXIV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXV	XXV	XXV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXVI	XXVI	XXVI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXVII	XXVII	XXVII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXVIII	XXVIII	XXVIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXIX	XXIX	XXIX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXX	XXX	XXX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXI	XXXI	XXXI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXII	XXXII	XXXII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXIII	XXXIII	XXXIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXIV	XXXIV	XXXIV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXV	XXXV	XXXV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXVI	XXXVI	XXXVI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXVII	XXXVII	XXXVII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXVIII	XXXVIII	XXXVIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXIX	XXXIX	XXXIX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXX	XXXX	XXXX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXI	XXXXI	XXXXI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXII	XXXXII	XXXXII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXIII	XXXXIII	XXXXIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXIV	XXXXIV	XXXXIV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXV	XXXXV	XXXXV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXVI	XXXXVI	XXXXVI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXVII	XXXXVII	XXXXVII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXVIII	XXXXVIII	XXXXVIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXIX	XXXXIX	XXXXIX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXX	XXXXX	XXXXX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXI	XXXXXI	XXXXXI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXII	XXXXXII	XXXXXII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXIII	XXXXXIII	XXXXXIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXIV	XXXXXIV	XXXXXIV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXV	XXXXXV	XXXXXV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXVI	XXXXXVI	XXXXXVI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXVII	XXXXXVII	XXXXXVII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXVIII	XXXXXVIII	XXXXXVIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXIX	XXXXXIX	XXXXXIX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXX	XXXXXX	XXXXXX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXI	XXXXXXI	XXXXXXI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXII	XXXXXXII	XXXXXXII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXIII	XXXXXXIII	XXXXXXIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXIV	XXXXXXIV	XXXXXXIV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXV	XXXXXXV	XXXXXXV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXVI	XXXXXXVI	XXXXXXVI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXVII	XXXXXXVII	XXXXXXVII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXVIII	XXXXXXVIII	XXXXXXVIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXIX	XXXXXXIX	XXXXXXIX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXX	XXXXXXX	XXXXXXX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXXI	XXXXXXXI	XXXXXXXI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXXII	XXXXXXXII	XXXXXXXII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXXIII	XXXXXXXIII	XXXXXXXIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXXIV	XXXXXXXIV	XXXXXXXIV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXXV	XXXXXXXV	XXXXXXXV	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXXVI	XXXXXXXVI	XXXXXXXVI	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXXVII	XXXXXXXVII	XXXXXXXVII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXXVIII	XXXXXXXVIII	XXXXXXXVIII	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXXIX	XXXXXXXIX	XXXXXXXIX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
XXXXXXX	XXXXXXX	XXXXXXX	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0</						

At least a few (in fact, a number) of table on following page, when necessary). If sample also equals or exceeds for at least also, do 100 percent inspection.

the first sampling plan above errors.

Acceptance number

Projection number: _____

Use corresponding single sampling plan (or alternatively, use multiple sampling plan) for α alternatively, use multiple sampling plan for β alternatively.

Use corresponding double notation plus (or minus) to indicate direction of this sample size.

• below, where available.

as below, where available).

TABLE IV-B — Multiple sampling plans for tightened inspection (Master table)
(Continued)

(see 4.9.3 and 4.9.4)

MIL-STD-105E

Sample size code letter	Sample size	Consumer's risk	Acceptable Quality Levels (tightened inspection)															
			0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.00	1.50	2.50	4.00	6.50	10.00
A	First	32	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Second	44	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Third	56	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fourth	68	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fifth	80	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Sixth	92	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Seventh	104	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
L	First	50	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Second	60	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Third	70	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fourth	80	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fifth	90	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Sixth	100	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Seventh	110	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
M	First	100	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Second	125	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Third	160	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fourth	200	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fifth	250	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Sixth	315	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Seventh	400	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
N	First	125	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Second	160	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Third	200	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fourth	250	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fifth	315	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Sixth	400	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Seventh	500	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
P	First	200	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Second	250	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Third	315	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fourth	400	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fifth	500	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Sixth	630	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Seventh	800	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
Q	First	315	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Second	400	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Third	500	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fourth	630	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fifth	800	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Sixth	1000	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Seventh	1250	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
R	First	500	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Second	630	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Third	800	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fourth	1000	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fifth	1250	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Sixth	1600	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Seventh	2000	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
S	First	800	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Second	1000	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Third	1250	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fourth	1600	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Fifth	2000	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Sixth	2500	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac
	Seventh	3150	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac	Ac

* Use first sampling plan unless arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 * Use first sampling plan unless arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 * Acceptance number.
 * Rejection number.
 * Use corresponding single sampling plan for alternatively, use multiple sampling plan below, when available.
 * Acceptance and rejection numbers at this sample size.

MULTIPLE
TIGHTENED

(see 4.9.3 and 4.9.4)

→	Use first sampling plan below given (refer to continuation of table on following page, when necessary). If sample size equals, or exceeds lot or batch size, do 100 percent inspection.
→	Use first sampling plan above given.
==	Acceptance number
==	Rejection number
≡	Use corresponding single sampling plan (or alternatively, use multiple sampling plan below, when available).
→→	Use corresponding double sampling plan (or alternatively, use multiple sampling plan below, when available).
≡≡	Acceptance not permitted at this sample size.
≡≡	If, after the final sample, the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot but initiate normal inspection (pages 4, 10, 14).

TABLE IV-C—Multiple sampling plans for reduced inspection (Master table)
(Continued)

(see 4.9.3 and 4.9.4)

MIL-STD-105E

Acceptable Quality Levels (induced inspection)†																								
Sample size code letter	Sample size	Com- mune sample size	0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000	
			Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He	Ac He
L	First	20																						
	Second	20																						
	Third	20																						
	Fourth	20																						
	Fifth	20																						
	Sixth	20																						
	Seventh	20																						
M	First	32																						
	Second	32																						
	Third	32																						
	Fourth	32																						
	Fifth	32																						
	Sixth	32																						
	Seventh	32																						
N	First	50																						
	Second	50																						
	Third	50																						
	Fourth	50																						
	Fifth	50																						
	Sixth	50																						
	Seventh	50																						
P	First	80																						
	Second	80																						
	Third	80																						
	Fourth	80																						
	Fifth	80																						
	Sixth	80																						
	Seventh	80																						
Q	First	125																						
	Second	125																						
	Third	125																						
	Fourth	125																						
	Fifth	125																						
	Sixth	125																						
	Seventh	125																						
R	First	200																						
	Second	200																						
	Third	200																						
	Fourth	200																						
	Fifth	200																						
	Sixth	200																						
	Seventh	200																						

Use first sampling plan below arrow. If sample also equals, or exceeds, lot or batch size, do 100 percent inspection.
Use first sampling plan above arrow (refer to preceding page when necessary).

Ac = Acceptance number
He = Inspection number
Ac = Acceptance number
He = Inspection number
Ac = Acceptance number
He = Inspection number

† If, after the final sample, the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but resample next inspection (see 4.10.1.4)

MULTIPLE
REDUCED

TABLE V-A—Average Outgoing Quality Limit Factors for Normal Inspection (Single sampling) *

(see 3.3)

Code Letter	Sample Size	Acceptable Quality Level																								
		0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000				
A	2																									
B	3																									
C	5																									
D	8																									
E	13																									
F	20																									
G	32																									
H	50																									
J	80																									
K	125																									
L	200																									
M	315																									
N	500																									
P	600																									
Q	1250																									
R	2000																									

* Notes: For the exact AOQL, the above values are multiplied by $(1 - \frac{\text{Sample size}}{\text{Lot or Batch size}})$

AOQL
NORMAL

TABLE V-B—Average Outgoing Quality Limits Factors for Tightened Inspection (Single sampling) •

(see 3.3)

Code letter		Sample size	Acceptable Quality Level																				
			0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000
A	3																						
B	3																						
C	5																						
D	8																						
E	13																						
F	20																						
G	32																						
H	50																						
I	80																						
K	125																						
L	200																						
M	315																						
N	500																						
P	800																						
Q	1250																						
R	2000																						
S	3150																						

• Note: For the exact AOQL, the above values must be multiplied by $(1 - \frac{\text{Sample size}}{\text{Lot or Batch size}})$ (see 11.4)

AOQL
TIGHTENED

TABLE VI-A—Limiting Quality (in percent defective) for which $P_d = 10$ Percent
(for Normal Inspection, Single sampling)

(see 4.11)

		Acceptable Quality Level														
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5
A	2	0.29	0.46	0.73	1.2	1.8	2.8	4.5	6.9	11	16	25	37	54	68	58
B	3															
C	5															
D	8	0.29	0.46	0.73	1.2	1.8	2.8	4.5	6.9	11	16	25	37	54	68	58
E	13															
F	20															
G	32	0.29	0.46	0.73	1.2	1.8	2.8	4.5	6.9	11	16	25	37	54	68	58
H	50															
J	80															
K	125	0.29	0.46	0.73	1.2	1.8	2.8	4.5	6.9	11	16	25	37	54	68	58
L	200															
M	315															
N	500	0.18	0.20	0.27	0.33	0.46	0.59	0.77	1.0	1.4	2.3	3.5	4.0	5.6	14	23
P	800															
Q	1250															
R	2000															

LQ (DEFECTIVES)
10.0%

TABLE VI-B—Limiting Quality (in defects per hundred units) for which $P_d = 10$ Percent
(for Normal Inspection, Single sampling)

(see 4.11)

Code letter		Sample size	Acceptable Quality Level																							
			0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000			
A	2																									
B	3																									
C	5																									
D	8																									
E	13																									
F	20																									
G	32																									
H	50																									
J	80																									
K	125																									
L	200																									
M	315																									
N	500																									
P	800																									
Q	1250																									
H	2000																									

TABLE VII-A—Limiting Quality (in percent defective) for which $P_a = 5$ Percent
(for Normal Inspection, Single sampling)

(see 4.11)

Code letter	Sample size	Acceptable Quality Level										
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0
A	2											
B	3											
C	5											
D	8											
E	13											
F	20											
G	32											
H	50											
J	80											
K	125											
L	200											
M	315											
N	500											
P	800											
Q	1250											
R	2000											

LQ (DEFECTIVES)
5.0%

TABLE VII-B—Limiting Quality (in defect. per hundred units) for which $P_a = 5$ Percent
(for Normal Inspection, Single sampling)

(see 4.11)

Code letter		Sample size	Acceptable Quality Level																		
			0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400
A	2																				
B	3																				
C	5																				
D	8																				
E	13																				
F	20																				
G	32																				
H	50																				
J	80																				
K	125																				
L	200																				
M	315																				
N	500																				
P	800																				
Q	1250	0.24																			
R	2000																				

TABLE VIII—Limit Numbers for Reduced Inspection

(see 4.7.3)

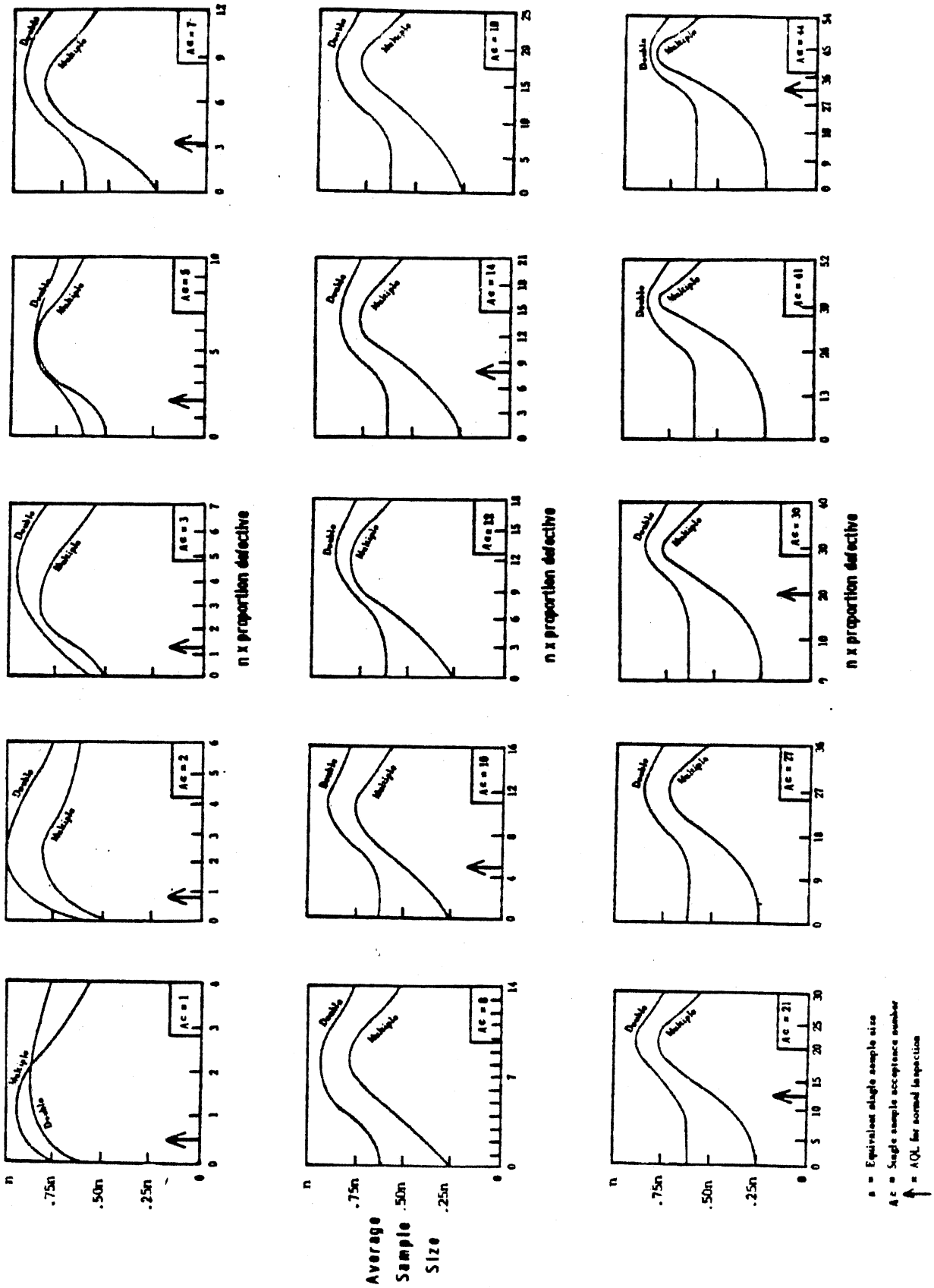
Number of sample units from last 10 lots or batches	Acceptable Quality Level															
	0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100
20 - 29
30 - 49
50 - 79
80 - 129
130 - 199
200 - 319
320 - 499
500 - 799
800 - 1249
1250 - 1999
2000 - 3149
3150 - 19999
5000 - 7999
8000 - 12499
12500 - 19999
20000 - 31499	0	0	2	4	8	14	22	40	68	115	186	315	540	910	1470	2430
31500 & Over	0	0	1	2	4	8	14	24	40	68	115	186	315	540	910	1470

LIMIT
NUMBERS

Denotes that the number of sample units from the last ten lots or batches is sufficient for reduced inspection for this AQL. In this instance more than ten lots or batches may be used for the calculation, provided that the lots or batches used are the most recent ones.

TABLE IX—Average sample size curves for double and multiple sampling
(normal and tightened inspection)

(see 4.12.2)



AVERAGE
SAMPLE SIZE

TABLE X-A—Tables for sample size code letter: A

CHART A - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

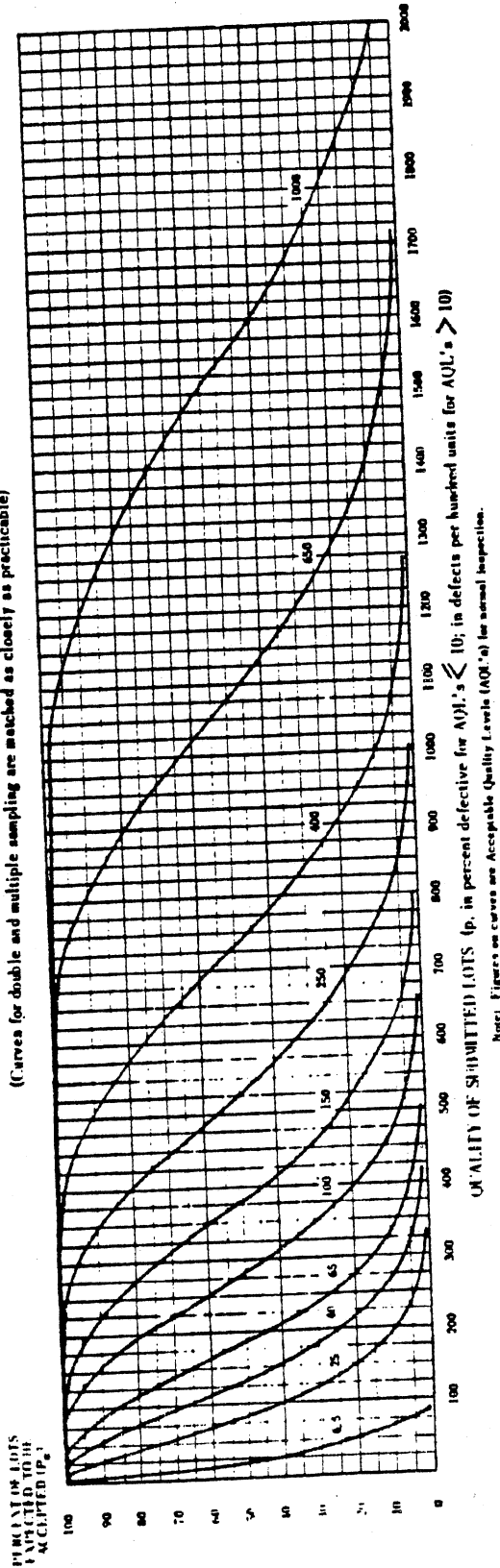


TABLE X-A-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

Acceptable Quality Levels (normal inspection)														
P _a	6.5	25	40	65	100	150	250	400	650	1000				
	p (in defects per hundred units)													
	p (in percent defective)	0.503	7.43	21.8	41.2	89.3	145	175	239	305	374	517	629	977
99.0	0.501												959	1122
95.0	2.53												995	1206
90.0	5.13												1073	1354
75.0	13.4												1214	1533
50.0	29.3												1383	1728
25.0	50.0												1568	1916
10.0	68.4												1748	2035
5.0	77.6												1862	2270
1.0	90.0												2088	
	×												1000	×
													×	
Acceptable Quality Levels (tightened inspection)														

Acceptable Quality Levels (normal inspection)

Acceptable Quality Levels (tightened inspection)

Acceptable Quality Levels (tightened inspection)

Acceptable Quality Levels (tightened inspection)

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Acceptable Quality Levels (tightened inspection)

Acceptable Quality Levels (tightened inspection)

Acceptable Quality Levels (tightened

Notes: Binomial distribution used for percent defective; Poisson approximation for percent defective per hundred units.

TABLE X-A-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: A

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																			Cumulative sample size												
		Less than 6.5	6.5	10	15	25	40	65	100	150	250	400	650	1000																			
															Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
Single	2	▽	0 1			1 2	2 3	3 4	5 6	7 8	9 10	11 12	13 14	15 16	18 19	21 22	27 28	30 31			2												
Double		▽	.	Use code Letter D	Use code Letter C	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)														
Multiple		▽														
		Less than 10	10	15	25	40	65	100	150	250	400	650	1000																				

Acceptable Quality Levels (tightened inspection)

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

. = Use single sampling plan above (or alternatively use code letter D).

(*) = Use single sampling (or alternatively use code letter B).

A

(Currents for double and multiple sampling are matched as closely as practicable)



OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P ₀	Acceptable Quality Levels (normal inspection)															
	4.0	15	25	40	65	100	150	250	400	650	1000					
	p (in defects per hundred units)															
	p (in percent defective)															
95.0	0.334	4.97	14.5	27.4	59.5	96.9	117	159	203	249	345	419	572	651	947	1029
95.0	1.70	11.8	27.3	45.5	87.1	133	157	206	256	308	415	496	643	748	1065	1152
90.0	3.45	17.7	36.7	58.2	105	155	181	234	288	343	456	541	716	804	1131	1222
75.0	9.14	32.0	57.6	84.5	141	199	228	287	347	408	530	623	809	903	1249	1344
50.0	20.6	55.9	89.1	122	189	256	289	356	422	489	622	722	922	1022	1389	1489
25.0	37.0	89.8	131	170	247	323	360	434	507	580	724	832	1045	1152	1539	1644
10.0	53.6	130	177	223	309	392	433	514	593	671	825	939	1165	1277	1683	1793
5.0	63.2	158	210	258	350	438	481	565	648	730	890	1008	1241	1356	1773	1886
1.0	78.5	221	280	335	437	533	580	671	761	848	1019	1145	1392	1513	1951	2069
	6.5	25	40	65	100	150	250	400	650	1000	1500	2500	4000	6500	10000	15000

Acceptable Quality Levels (tightened inspection)

Refer to defects per hundred units.

Note: Binomial distributions used for defective computerized. Poisson for defective per person on wire.

TABLE X-B-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: B

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																	Cumulative sample size	
		Less than 4.0	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000					
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re		
Single	3	▽	0 1			1 2 2 3 3 4			5 6 7 8	8 9 10 11 12	13 14 15			22 27 28 30 31	41 42 44 45			3		
Double	2 4	▽	•	Use code Letter A	Use code Letter D	0 2 0 3 1 4 2 5 3 7			5 6 7 8 9 11 12 13 15 16 18	7 11 9 14 11 16 15 20 17 22 23 29 25 31							2 4			
Multiple		▽	•																	
		Less than 6.5	6.5	10	15	25	40	65	100	150	250	400	650	1000	×	Acceptable Quality Levels (tightened inspection)				

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above (or alternatively use code letter E)

++ = Use double sampling plan above (or alternatively use code letter D)

B

TABLE X-C—Tables for sample size code letter: C

CHART C - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

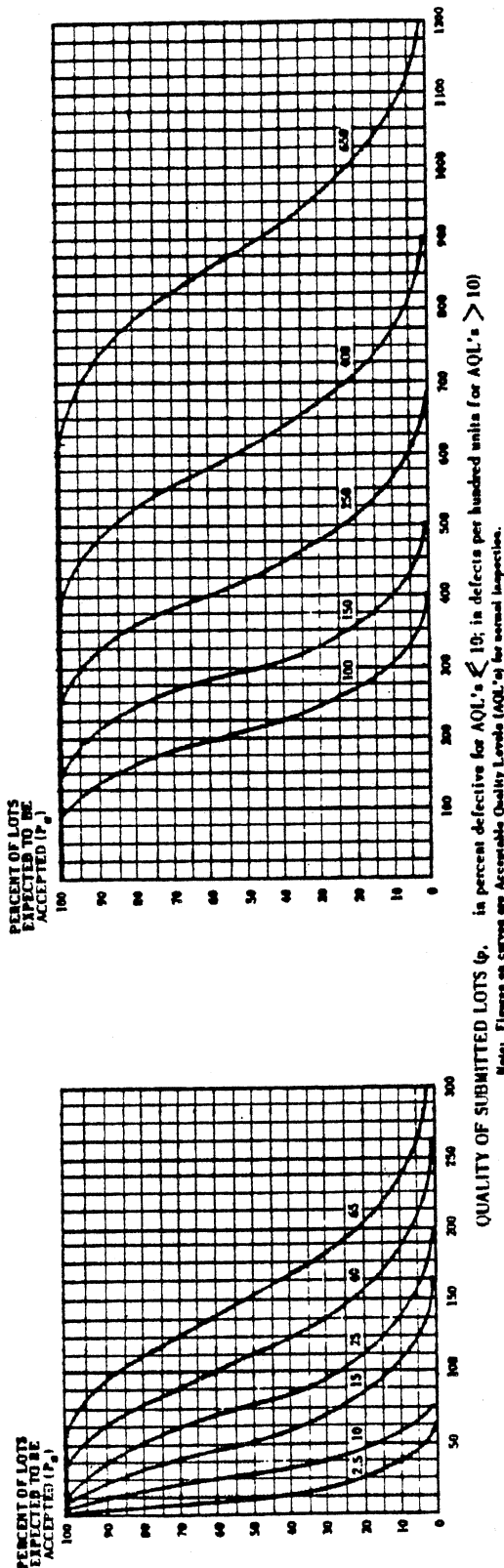


TABLE X-C-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _a	Acceptable Quality Levels (normal inspection)																	
	2.5	10	2.5	10	15	25	40	65	100	150	250	400	650					
	p (in defects per hundred units)																	
	p (in percent defective)																	
99.0	0.201	3.27	0.201	2.97	8.72	16.5	37.5	58.1	70.1	95.4	122	150	207	251	343			391
95.0	1.32	7.64	1.03	7.11	16.4	27.3	52.3	79.6	93.9	123	154	185	249	298	398	449	639	691
90.0	2.09	11.2	2.11	10.6	22.0	34.9	63.0	93.1	109	140	173	206	273	325	429	482	679	733
75.0	5.59	19.4	5.75	19.2	34.5	50.7	84.4	119	137	172	208	245	318	374	485	542	749	806
50.0	12.9	31.4	13.9	33.6	53.5	73.4	113	153	173	213	253	293	373	433	553	613	833	893
25.0	24.2	45.4	27.7	53.9	78.4	102	148	194	216	260	304	348	435	499	627	691	923	986
10.0	36.9	58.4	46.1	77.8	106	134	185	235	260	308	356	403	495	564	699	766	1010	1076
5.0	45.1	66.7	59.9	94.9	126	155	210	263	289	339	389	438	534	605	745	814	1064	1131
1.0	60.2	77.8	92.1	133	168	201	262	320	348	403	456	509	612	687	835	908	1171	1241
	4.0	7.0	4.0	15	25	40	65	100	150	250	400	650	1000	1500	2500	4000	6500	8000
	Acceptable Quality Levels (tightened inspection)																	

Note: Binomial distribution used for percent defective computations; Poisson for defects per hundred units.

TABLE X-C-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: C

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (tightened inspection)																Cumulative sample size																	
		Less than 2.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000																			
Single	5	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																
		▽	0	1		1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	18	19	21	22	27	28	30	31	41	42	44	45
Double	3 6	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																
		▽	•			0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	15	20	17	22	23	29	25	31
Multiple		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																
		▽	•			1	2	3	4	4	5	6	7	8	9	11	12	13	15	16	18	19	23	24	26	27	34	35	37	38	52	53	56	57	
		Less than 4.0	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000																				

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number.

Re = Rejection number.

• = Use single sampling plan above (or alternatively use code letter f)

++ = Use double sampling plan above (or alternatively use code letter D)

TABLE X-D—Tables for sample size code letter: D

CHART D - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

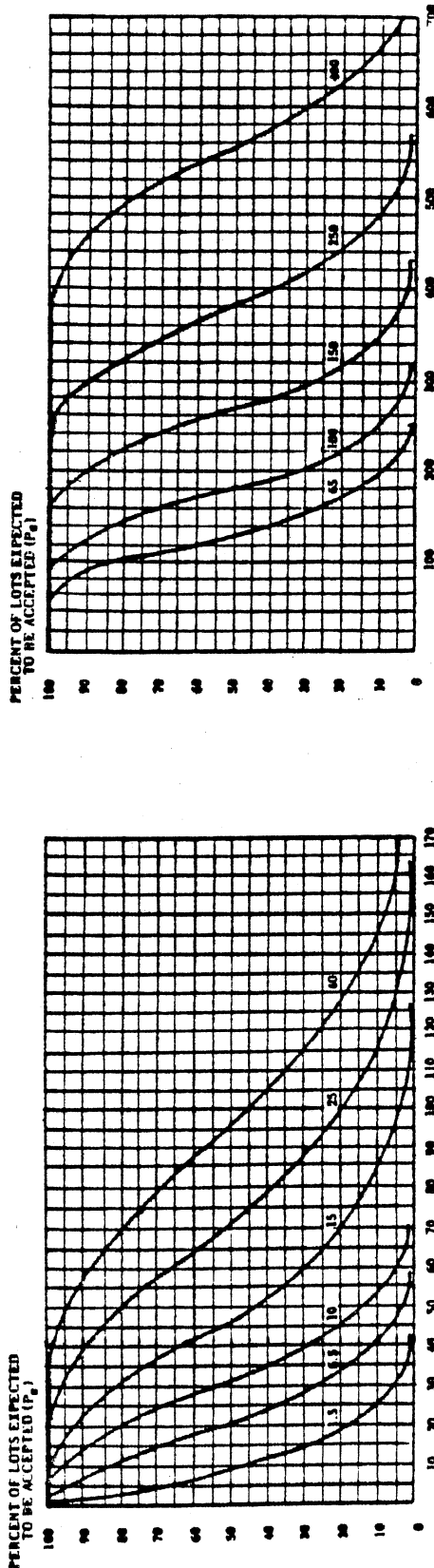


TABLE X-D-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _a	Acceptable Quality Levels (normal inspection)														
	1.5	5.5	10	15.5	10	6.5	15	25	40	65	100	150	250	400	
	p (in defects per hundred units)														
p (in percent defective)															
	0.125	1.97	6.06	10.3	22.3	36.3	43.8	59.6	76.2	93.5	129	157	215	244	386
99.0	0.125	1.97	6.06	10.3	22.3	36.3	43.8	59.6	76.2	93.5	129	157	215	244	386
95.0	0.639	4.64	11.1	17.1	32.7	49.8	58.7	77.1	96.1	116	156	186	249	291	432
90.0	1.31	6.06	14.7	21.8	39.4	58.2	67.9	87.8	108	129	171	203	268	301	458
75.0	3.53	12.1	22.1	31.7	52.7	74.5	85.5	108	130	153	199	234	303	339	504
50.0	8.30	20.1	32.1	45.9	70.9	95.9	108	133	158	183	233	271	346	383	558
25.0	15.9	30.3	43.3	63.9	92.8	121	135	163	190	217	272	312	392	432	617
10.0	25.0	40.6	53.8	83.5	116	147	162	193	222	252	309	352	437	479	672
5.0	31.2	47.1	60.0	96.9	131	164	180	212	243	274	334	378	465	509	707
1.0	43.8	59.0	70.7	126	164	200	218	252	285	318	382	429	522	568	776
	2.5	10	15	25	40	65	100	150	250	400	600	900	1500	2500	4000
Acceptable Quality Levels (tightened inspection)															
	2.5	10	15	25	40	65	100	150	250	400	600	900	1500	2500	4000

Note: Biased distributions; Percent defective (normal inspection); Percent defective (tightened inspection); Percent defective (normal inspection); Percent defective (tightened inspection).

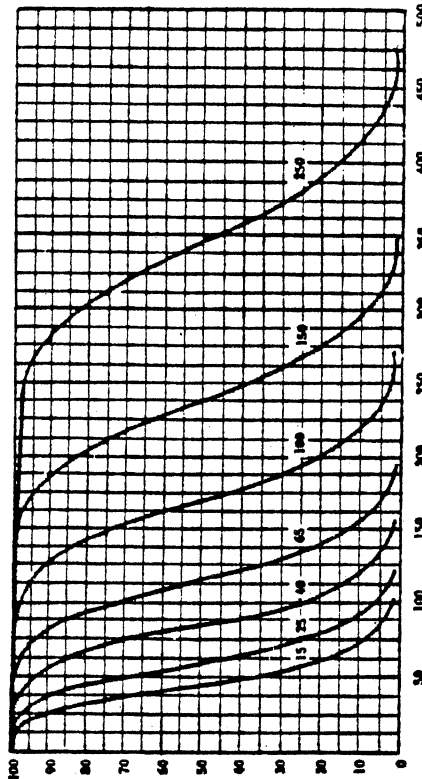
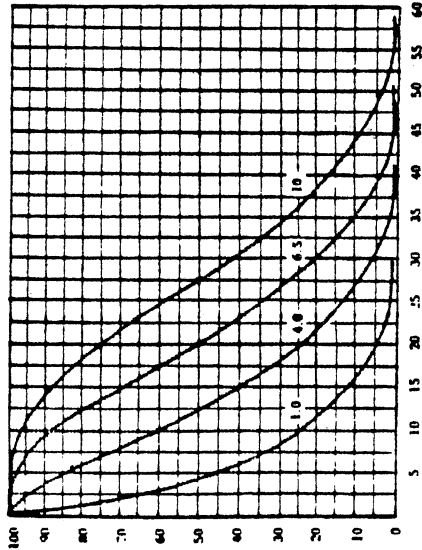
Δ	=	Use next preceding sample size code letter for which acceptance and rejection numbers are available.
∇	=	Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
Ac	=	Acceptance number
Re	=	Rejection number
•	=	Use single sampling plan above (or alternatively use code letter G)
•	=	Acceptance not permitted at this sample size.

TABLE X-E—Tables for sample size code letter: E

CHART E - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

PERCENT OF LOTS
ACCEPTED (100 -
REJECTION)



QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)
Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-E-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _o	Acceptable Quality Levels (normal inspection)																				Acceptable Quality Levels (tightened inspection)																			
	p (in percent defective)										p (in defects per hundred units)										p (in defects per hundred units)																			
	1.0	4.0	6.5	10	15	25	40	65	100	150	250	1.0	4.0	6.5	10	15	25	40	65	100	150	250	1.0	4.0	6.5	10	15	25	40	65	100	150	250							
99.0	0.077	1.16	3.58	6.75	11.3	18.2	27.0	36.7	46.9	57.5	69.6	82.1	97.4	113	144	167	192	217	233	286	313	409	435	1.0	4.0	6.5	10	15	25	40	65	100	150	250						
95.0	0.374	2.81	6.60	11.3	20.1	30.6	36.1	47.5	59.2	71.1	85.7	105	125	165	208	288	310	250	238	266	266	266	266	1.0	4.0	6.5	10	15	25	40	65	100	150	250						
90.0	0.807	4.17	8.80	14.2	24.2	35.8	41.8	54.0	66.5	79.2	105	125	165	208	288	310	250	238	266	266	266	266	266	1.0	4.0	6.5	10	15	25	40	65	100	150	250						
75.0	2.19	7.41	13.4	19.9	32.5	45.8	52.6	66.3	80.2	94.1	122	144	187	208	288	310	250	238	266	266	266	266	266	1.0	4.0	6.5	10	15	25	40	65	100	150	250						
50.0	5.19	12.6	20.0	27.5	43.6	59.0	66.7	82.1	97.4	113	144	167	213	236	321	344	250	238	266	266	266	266	266	1.0	4.0	6.5	10	15	25	40	65	100	150	250						
25.0	10.1	19.4	28.0	36.1	57.1	74.5	83.1	100	117	134	167	192	241	266	355	379	250	238	266	266	266	266	266	1.0	4.0	6.5	10	15	25	40	65	100	150	250						
10.0	16.2	26.8	36.0	44.4	71.3	90.5	100	119	137	155	190	217	269	295	388	414	250	238	266	266	266	266	266	1.0	4.0	6.5	10	15	25	40	65	100	150	250						
5.0	20.6	31.6	41.0	49.5	80.9	101	111	130	150	168	205	233	286	313	409	435	250	238	266	266	266	266	266	1.0	4.0	6.5	10	15	25	40	65	100	150	250						
1.0	29.8	41.3	50.6	58.8	101	123	134	155	176	196	235	264	321	349	450	477	250	238	266	266	266	266	266	1.0	4.0	6.5	10	15	25	40	65	100	150	250						
1.5	6.5	10	15	25	40	65	100	150	250	1.5	6.5	10	15	25	40	65	100	150	250	1.5	6.5	10	15	25	40	65	100	150	250	1.5	6.5	10	15	25	40	65	100	150	250	

Note: Binomial distribution used for percent defective compositions. Figures for defects per hundred units.

TABLE X-E-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: E

MIL-STD-105E

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Higher than 250														
		Less than 1.0	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	ReAc	ReAc	ReAc	ReAc	ReAc																
		Ac	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc	ReAc															
Single	13	▽	0	1		1	2	2	3	3	4	5	6	7	8	9	10	11	12	13	14	15	18	19	21	22	27	28	30	31	41	42	44	45	△	13
	8	▽			Use code Letter	0	2	0	3	1	4	2	5	3	7	3	5	9	6	10	7	11	9	14	11	16	15	20	17	22	23	29	25	31	△	8
Double	16		•			1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27	34	35	37	38	52	53	56	57	16
	3	▽	•		Use code Letter	0	2	0	2	0	3	0	4	0	4	0	4	0	5	0	6	1	7	1	8	2	9	3	10	4	12	6	15	6	16	3
Multiple	6					0	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14	10	17	11	19	16	25	17	27	6
	9					0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	13	8	13	11	17	13	19	17	24	19	27	26	36	29	39	9
	12					0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25	24	31	27	34	37	46	40	49	12
	15					1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	25	29	32	37	36	40	49	55	53	54	15
	18					1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33	40	43	45	47	61	64	65	68	18
	21					2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38	48	49	53	54	72	73	77	78	21
		Less than 1.5	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	Higher than 250																					
		Acceptable Quality Levels (tightened inspection)																																		

- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number.
- Re = Rejection number.
- = Use single sampling plan above (or alternatively use code letter H)
- = Acceptance not permitted at this sample size.

FF

TABLE X-F—Tables for sample size code letter: F

CHART F - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

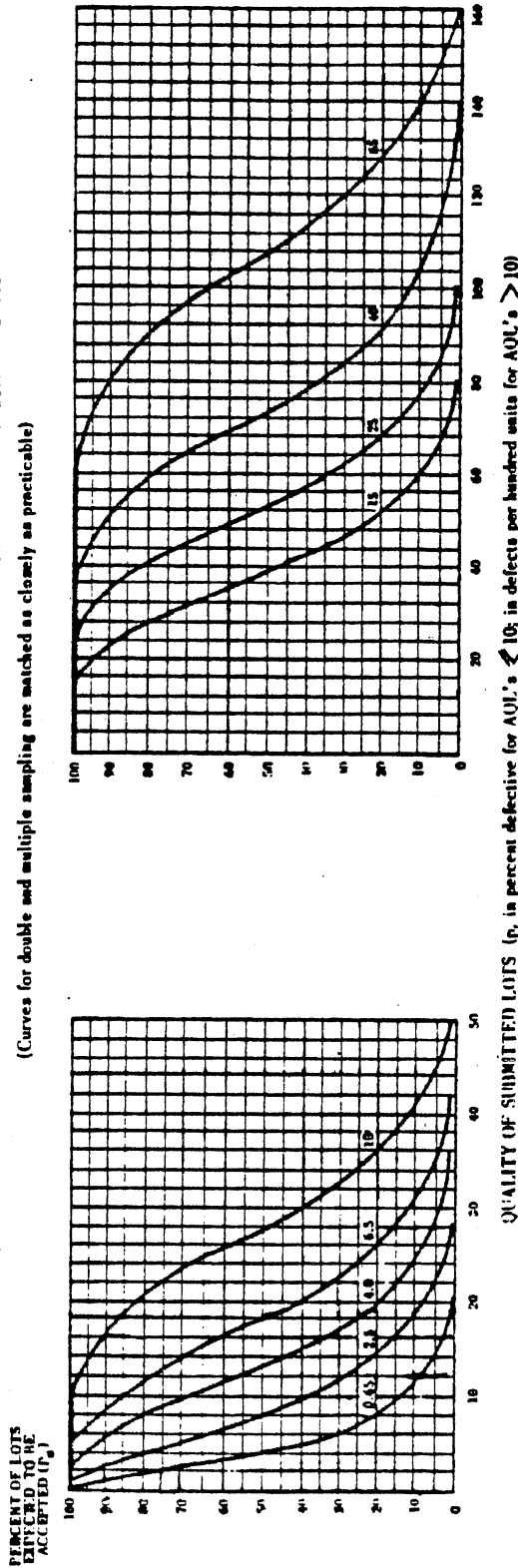


TABLE X-F-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _a	Acceptable Quality Levels (normal inspection)												
	p (in percent defective)						p (in defects per hundred units)						
	0.65	2.5	4.0	6.5	10	15	0.65	2.5	4.0	6.5	10	15	25
99.0	0.0502	0.759	2.27	4.36	9.75	0.0503	0.743	2.18	4.12	8.93	14.5	17.5	23.9
95.0	0.256	1.81	4.22	7.14	14.0	0.256	1.78	4.09	6.83	13.1	19.9	23.5	30.8
90.0	0.525	2.69	5.64	9.03	16.6	0.527	2.66	5.51	8.72	15.8	23.3	27.2	35.1
75.0	1.43	4.81	8.70	12.8	21.6	1.44	4.81	8.64	12.7	21.1	29.8	34.2	43.1
50.0	3.41	8.25	13.1	18.1	27.9	3.47	8.39	13.4	18.4	28.4	38.3	43.3	53.3
25.0	6.70	12.9	18.7	24.2	34.8	6.93	13.5	19.6	25.5	37.1	48.4	54.0	65.1
10.0	10.9	18.1	24.5	30.4	41.5	11.5	19.4	26.6	33.4	46.4	58.9	65.0	77.0
5.0	13.9	21.6	28.3	34.4	45.6	15.0	23.7	31.5	38.8	52.6	65.7	72.2	84.8
1.0	20.6	28.9	35.8	42.1	53.2	23.0	33.2	42.0	50.2	65.5	80.0	87.0	101
	1.9	4.0	6.5	10	15	25	40	65	10	15	25	40	65

Notes: Binomial distribution used for "normal" defective computations; Poisson for defects per hundred units.

TABLE X-F-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: F

MIL-STD-105E

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																Cumulative sample size															
		Less than 0.65	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	Higher than 65																			
														Ac	Re																		
Single	20	▽	0	1		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	△					
Double	13	▽	.		Use code Letter	0	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	△					
	26			Use code Letter	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27		
Multiple	5	▽	.		E	2	2	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27
	10					2	2	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27
	15					2	2	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27
	20					2	2	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27
	25					2	2	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27
	30					2	2	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27
	35					2	2	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27
		Less than 1.0	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	Higher than 65																				
Acceptable Quality Levels (tightened inspection)																																	

- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number
- Re = Rejection number
- .
- Use single sampling plan above (or alternatively use code letter J)
- Acceptance not permitted at this sample size.

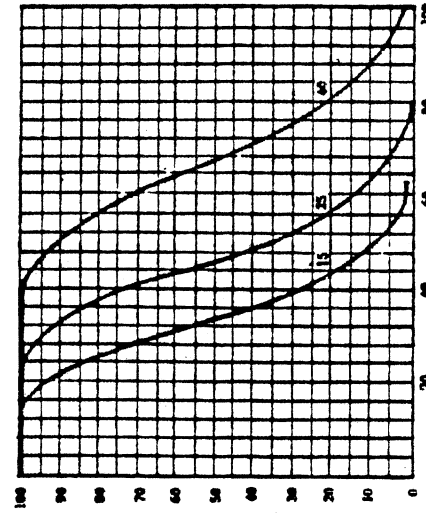
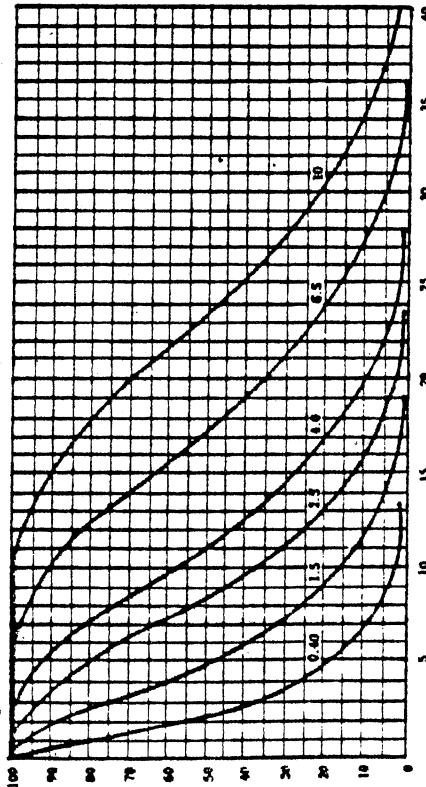


TABLE X-G—Tables for sample size code letter: G

CHART G - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

PERCENT OF LOTS
EXPECTED TO BE
ACCEPTED (P_a)



QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)

Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-G-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _a	Acceptable Quality Levels (normal inspection)																	
	0.40	1.5	2.5	4.0	6.5	10	0.40	1.5	2.5	4.0	6.5	10	0.40	1.5	25	40		
	p (in percent defective)						p (in defects per hundred units)											
99.0	0.0314	0.471	1.40	2.67	5.88	9.73	0.0314	0.464	1.36	2.57	5.58	9.08	11.0	14.9	19.1	23.4	32.3	39.3
95.0	0.160	1.12	2.60	4.38	8.50	13.1	0.160	1.11	2.56	4.27	8.17	12.4	14.7	19.3	24.0	28.9	38.9	46.5
90.0	0.329	1.67	3.49	5.56	10.2	15.1	0.329	1.66	3.44	5.45	9.85	14.6	17.0	21.9	27.0	32.2	42.7	50.8
75.0	0.895	3.01	5.42	7.98	13.4	19.0	0.899	3.00	5.40	7.92	13.2	18.6	21.4	26.9	32.6	38.2	49.7	58.4
50.0	2.14	5.19	8.27	11.4	17.5	23.7	2.17	5.24	8.36	11.5	17.7	24.0	27.1	33.3	39.6	45.8	58.3	67.7
25.0	4.24	8.19	11.9	15.4	22.3	29.0	4.33	8.41	12.3	16.0	23.2	30.3	33.8	40.7	47.6	54.4	67.9	78.0
10.0	6.94	11.6	15.8	19.7	27.1	34.1	7.20	12.2	16.6	20.9	29.0	36.8	40.6	48.1	55.6	62.9	77.4	88.1
5.0	8.94	14.0	18.4	22.5	30.1	37.2	9.36	14.8	19.7	24.2	32.9	41.1	45.1	53.0	60.8	68.4	83.4	94.5
1.0	13.4	19.0	23.8	28.1	36.0	43.2	14.4	20.7	26.3	31.4	41.0	50.0	54.4	63.0	71.3	79.5	95.6	107
	0.65	2.5	4.0	5.5	10	15	0.65	2.5	4.0	6.5	10	15	25	40	40	40	40	40

Acceptable C Levels (tightened inspection)

Acceptable ' Levels (tightened inspection)

TABLE X-G-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: G

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																												Cumulative sample size
		Less than 0.40	0.40		0.65		1.0		1.5		2.5		4.0		6.5		10		15		25		40		Higher than 40					
			Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
Single	32	▽		0	1																							32		
Double	20	▽																											20	
	40																												40	
Multiple	8	▽																											8	
	16																												16	
	24																												24	
	32																												32	
	40																												40	
	48																												48	
	56																												56	
		Less than 0.65		0.65		1.0		1.5		2.5		4.0		6.5		10		15		25		40		Higher than 40						

Acceptable Quality Levels (tightened inspection)																											

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number.

Re = Rejection number.

• = Use single sampling plan above (or alternatively use code letter K)

* = Acceptance not permitted at this sample size.

TABLE X-II-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: H

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Cumulative sample size																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
		Less than 0.25	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	Higher than 25																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
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△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

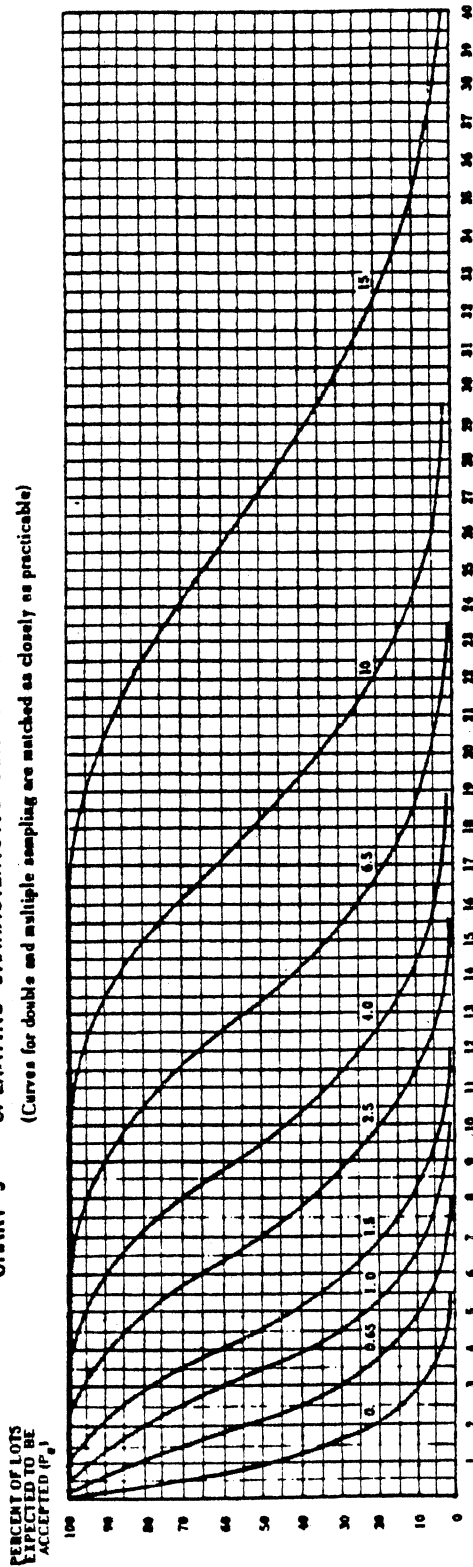
• = Use single sampling plan above (or alternatively use code letter L)

• = Acceptance not permitted at this sample size.

TABLE X-J—Tables for sample size code letter: J

CHART J - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)



QUALITY OF SUBMITTED LOTS (p , in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)

Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-J-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _d	Acceptable Quality Levels (normal inspection)																					
	0.15	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000	1500	2500	4000	
	p (in percent defective)										p (in defects per hundred units)											
99.0	0.0126	0.187	0.550	1.04	2.28	3.73	4.51	6.17	7.88	9.76	0.0126	0.186	0.545	1.03	2.23	3.63	4.38	5.96	7.62	9.35	12.9	15.7
95.0	0.0641	0.446	1.03	1.73	3.32	5.07	6.00	7.93	9.89	11.9	0.0641	0.444	1.02	1.71	3.27	4.98	5.87	7.71	9.61	11.6	15.6	18.6
90.0	0.132	0.667	1.39	2.20	3.99	5.91	6.90	8.95	11.0	13.2	0.132	0.665	1.38	2.18	3.94	5.82	6.79	8.78	10.8	12.9	17.1	20.3
75.0	0.359	1.201	2.16	3.18	5.30	7.50	8.61	10.9	13.2	15.5	0.360	1.20	2.16	3.17	5.27	7.45	8.55	10.8	13.0	15.3	19.9	23.4
50.0	0.863	2.09	3.33	4.57	7.06	9.55	10.9	13.3	15.8	18.3	0.866	2.10	3.34	4.59	7.09	9.59	10.8	13.3	15.8	18.3	23.3	27.1
25.0	1.72	3.33	4.84	6.30	9.14	11.9	13.3	16.0	18.6	21.3	1.73	3.37	4.90	6.39	9.28	12.1	13.5	16.3	19.0	21.7	27.2	31.2
10.0	2.84	4.78	6.52	8.16	11.3	14.3	15.7	18.6	21.4	24.2	2.88	4.86	6.65	8.35	11.6	14.7	16.2	19.3	22.2	25.2	30.9	35.2
5.0	3.68	5.79	7.66	9.41	12.7	15.8	17.3	20.3	23.2	26.0	3.74	5.93	7.87	9.69	13.1	16.4	18.0	21.2	24.3	27.4	33.4	37.8
1.0	5.59	8.01	10.1	12.0	15.6	18.9	20.5	23.6	26.6	29.5	5.76	8.30	10.5	12.6	16.4	20.0	21.8	25.2	28.5	31.8	38.2	42.9
	0.25	1.0	1.5	2.5	4.0	6.5	10	15	20	25	0.25	1.0	1.5	2.5	4.0	6.5	10	15	20	25	30	35
	Acceptable Quality Levels (tightened inspection)																					

Note: Binomial distribution used for percent defective computations; Poisson for defects per hundred units.

TABLE X-J-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: J

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																		Cumulative sample size						
		Less than 0.15	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	Higher than 15												
														Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re
Single	80	▽	0 1			1 2	2 3	3 4	5 6	7 8	9 10	11 12	13 14	15 16	17 18	19 20	21 22	△	80							
Double	50	▽	•		Use code Letter	0 2	0 3	1 4	2 5	3 7	5 9	6 10	7 11	9 14	11 16		△	50								
	100				Use code Letter	1 2	3 4	4 5	6 7	8 9	11 12	12 13	15 16	18 19	23 24	26 27		100								
Multiple	20	▽	•			• 2	• 2	• 3	• 4	0 4	0 5	0 6	1 7	1 8	2 9	△	20									
	40					• 2	0 3	0 3	1 5	1 6	2 7	3 8	3 9	4 10	6 12	7 14	40									
	60					0 2	0 3	1 4	2 6	3 8	4 9	6 10	7 12	11 13	17 19		60									
	80					0 3	1 4	2 5	3 7	5 10	6 11	8 13	10 15	12 17	16 22	19 25	80									
	100					1 3	2 4	3 6	5 8	7 11	9 12	11 15	14 17	17 20	22 25	25 29	100									
	120					1 3	3 5	4 6	7 9	10 12	14 16	14 17	18 20	21 23	27 29	31 33	120									
	140					2 3	4 5	6 7	9 10	13 14	15 16	18 19	21 22	25 26	32 33	37 38	140									
		Less than 0.25	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	Higher than 15		Acceptable Quality Levels (tightened inspection)											

Note: All values given in above table based on distribution as an approximation to the binomial.

TABLE X-K-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: K

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																			Cumulative sample size									
		Less than 0.10	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	Higher than 10																
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re											
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re											
Single	125	▽	0	1																△	125									
	80	▽	•		Use code Letter	0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	80		
Double	160						1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27	160	
		▽	•		J																									
Multiple	32	▽	•		M																									32
	64																													64
	96																													96
	128																													128
	160																													160
	192																													192
	224																													224
		Less than 0.15	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	Higher than 10																	
			×						×	×	×	×	×	×	×	×	×	×	×	×	×	×	×	×	×	×	×	×	×	×
		Acceptable Quality Levels (tightened inspection)																												

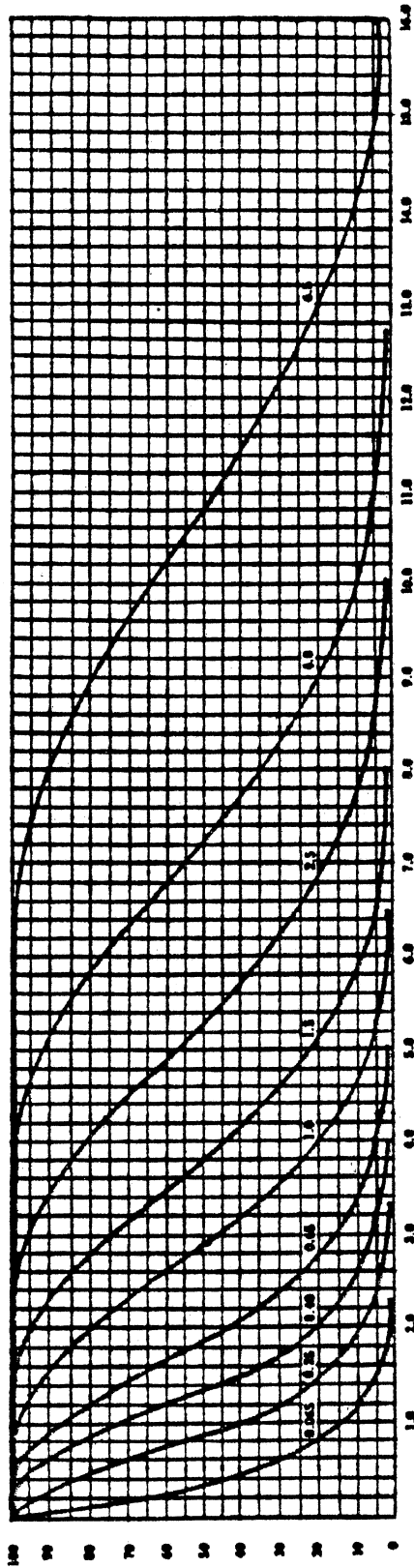
- △ Use next preceding sample size code letter for which acceptance and rejection numbers are available.
- ▽ Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac Acceptance number
- Re Rejection number
- Use single sampling plan above (or alternatively use code letter H)
- Acceptance not permitted at this sample size.

K

TABLE X-L—Tables for sample size code letter: L

CHART L - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

PERCENT OF LOTS
EXPECTED TO BE
ACCEPTED (P_a)QUALITY OF SUBMITTED LOTS (p , in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)

Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-L-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P_a	Acceptable Quality Levels (normal inspection)										
	0.065	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10.0	14.0
	p (in percent defective or defects per hundred units)										
99.0	0.00503	0.0175	0.216	0.412	0.893	1.45	1.75	2.39	3.05	3.74	5.17
95.0	0.0256	0.178	0.409	0.683	1.31	1.99	2.35	3.08	3.84	4.62	6.22
90.0	0.0527	0.266	0.551	0.872	1.50	2.33	2.72	3.51	4.32	5.15	6.84
75.0	0.144	0.481	0.864	1.27	2.11	2.90	3.42	4.31	5.21	6.12	7.95
50.0	0.347	0.839	1.34	1.84	2.84	3.84	4.33	5.33	6.33	7.33	9.33
25.0	0.693	1.35	1.96	2.55	3.71	4.83	5.40	6.51	7.61	8.70	10.9
10.0	1.15	1.84	2.66	3.34	4.64	5.89	6.50	7.70	8.89	10.1	12.4
5.0	1.50	2.37	3.15	3.86	5.26	6.57	7.22	8.40	9.72	10.9	13.3
1.0	2.30	3.32	4.20	5.02	6.55	8.00	8.70	10.1	11.4	12.7	15.3
	0.10	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10.0	14.0	20.0
Acceptable Quality Levels (tightened inspection)											
	0.065	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10.0	14.0
	p (in percent defective or defects per hundred units)										
99.0	0.00503	0.0175	0.216	0.412	0.893	1.45	1.75	2.39	3.05	3.74	5.17
95.0	0.0256	0.178	0.409	0.683	1.31	1.99	2.35	3.08	3.84	4.62	6.22
90.0	0.0527	0.266	0.551	0.872	1.50	2.33	2.72	3.51	4.32	5.15	6.84
75.0	0.144	0.481	0.864	1.27	2.11	2.90	3.42	4.31	5.21	6.12	7.95
50.0	0.347	0.839	1.34	1.84	2.84	3.84	4.33	5.33	6.33	7.33	9.33
25.0	0.693	1.35	1.96	2.55	3.71	4.83	5.40	6.51	7.61	8.70	10.9
10.0	1.15	1.84	2.66	3.34	4.64	5.89	6.50	7.70	8.89	10.1	12.4
5.0	1.50	2.37	3.15	3.86	5.26	6.57	7.22	8.40	9.72	10.9	13.3
1.0	2.30	3.32	4.20	5.02	6.55	8.00	8.70	10.1	11.4	12.7	15.3
	0.10	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10.0	14.0	20.0

Note: All values given in above table based on distribution as an approximation to the binomial.

TABLE X-L-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: L

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																Higher than 6.5											
		Less than 0.065	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	Higher than 6.5															
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re												
Single	200	▽	0	1		1	2	2	3	3	4	5	6	7	8	9	10	11	12	13	14	15	18	19	21	22	△		
					Use																								
Double	125	▽	.		Use	code Letter	0	2	0	3	1	4	2	5	3	7	3	5	9	6	10	7	11	9	14	11	16	△	
	250						1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27	
Multiple	50	▽	.		K	N	0	2	0	3	1	4	2	5	3	7	3	5	9	6	10	7	11	9	14	11	16	△	
	100						0	2	0	3	1	4	2	5	3	7	3	5	9	6	10	7	11	9	14	11	16	△	
	150						0	2	0	3	1	4	2	5	3	7	3	5	9	6	10	7	11	9	14	11	16	△	
	200						0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25	
	250						1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	29		
	300						1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33	
	350						2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38	
		Less than 0.10	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	Higher than 6.5																
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
		▽	0	1		1	2	2	3	3	4	5	6	7	8	9	10	11	12	13	14	15	18	19	21	22	24	26	27
		▽	.		Use	code Letter	0	2	0	3	1	4	2	5	3	7	3	5	9	6	10	7	11	9	14	11	16	△	
		▽	.				1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27	
		▽	.				0	2	0	3	1	4	2	5	3	7	3	5	9	6	10	7	11	9	14	11	16	△	
							0	2	0	3	1	4	2	5	3	7	3	5	9	6	10	7	11	9	14	11	16	△	
							0	2	0	3	1	4	2	5	3	7	3	5	9	6	10	7	11	9	14	11	16	△	
							0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25	
							1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	29		
							1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33	
							2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38	

Acceptable Quality Levels (tightened inspection)

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
 Ac = Acceptance number
 Re = Rejection number
 . = Use single sampling plan above (or alternatively use code letter P)
 * = Acceptance not permitted at this sample size.

TABLE X-M—Tables for sample size code letter: M

CHART M - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

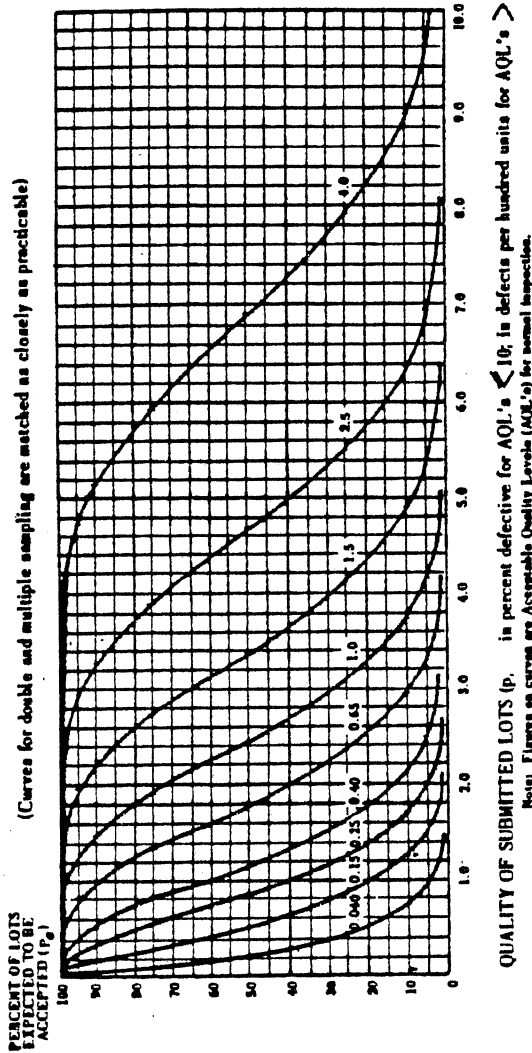


TABLE X-M-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P_a	Acceptable Quality Levels (normal inspection)										
	0.040	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.88	10.9
	p (in percent defective or in defects per hundred units)										
99.0	0.00319	0.0472	0.138	0.261	0.567	0.923	1.11	1.51	1.94	2.37	3.28
95.0	0.0163	0.113	0.260	0.434	0.830	1.26	1.49	1.96	2.44	2.94	3.95
90.0	0.0335	0.169	0.350	0.534	1.00	1.48	1.72	2.23	2.74	3.27	4.34
75.0	0.0913	0.305	0.548	0.805	1.34	1.89	2.17	2.74	3.31	3.89	5.05
50.0	0.220	0.533	0.849	1.17	1.80	2.43	2.75	3.39	4.02	4.66	5.93
25.0	0.440	0.855	1.24	1.62	2.36	3.07	3.43	4.13	4.83	5.52	6.90
10.0	0.731	1.23	1.69	2.12	2.94	3.74	4.13	4.89	5.64	6.39	7.86
5.0	0.951	1.51	2.00	2.46	3.34	4.17	4.58	5.38	6.17	6.95	8.47
1.0	1.46	2.11	2.67	3.19	4.16	5.08	5.52	6.40	7.24	8.08	9.71
0.065		0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.88	10.9	17.7
	Acceptable Quality Levels (tightened inspection)										

Notes: All values given in above table are Poisson distribution as an approximation to the Binomial.

TABLE X-M-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: M

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																																
		Less than 0.040	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	Higher than 4.0																				
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re					
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re					
Single	315	▽	0	1						1	2	2	3	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	△
Double	200	▽	.							0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	△		
	400									1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27			
Multiple	80	▽	.							0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	△		
	160									0	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14			
	240									0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	8	13	11	17	13	19			
	320									0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25			
	400									1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	25	29			
	480									1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33			
	560									2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38			
		Less than 0.065	0.065							0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	Higher than 4.0															
		Acceptable Quality Levels (tightened inspection)																																

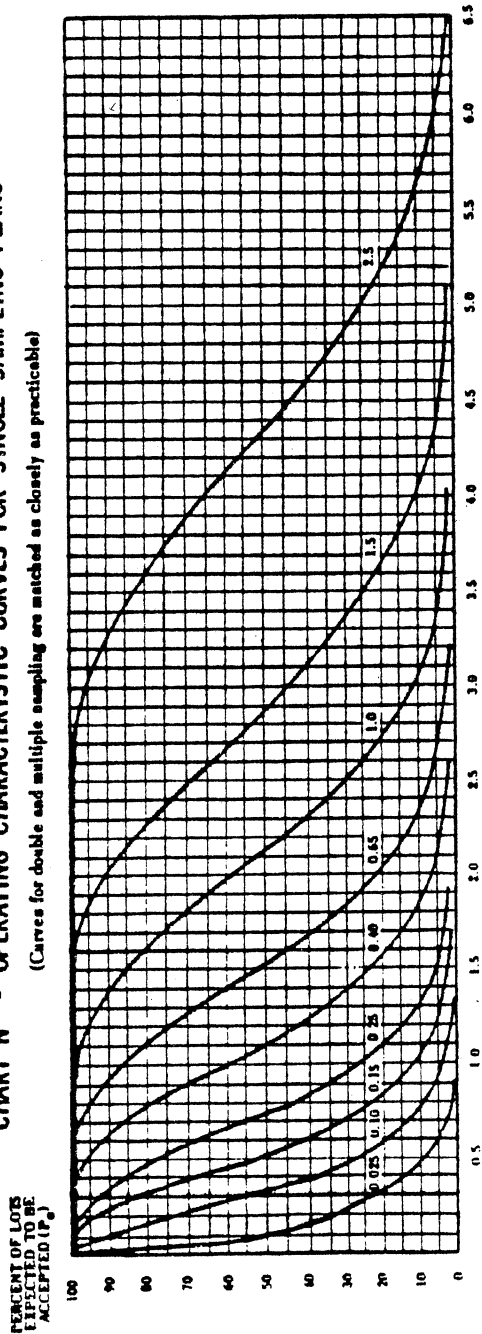
- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
 Ac = Acceptance number.
 Re = Rejection number.
 . = Use single sampling plan above (or alternatively use code letter Q)
 • = Acceptance not permitted at this sample size.

M

TABLE X-N—Tables for sample size code letter: N

CHART N - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)



Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-N-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _a	Acceptable (Quality Levels (normal inspection))										
	0.025	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5	3.0
	p (in percent defective or in defects per hundred units)										
99.0	0.00201	0.0297	0.0472	0.165	0.357	0.581	0.701	0.954	1.22	1.50	2.07
95.0	0.0103	0.0711	0.164	0.273	0.523	0.796	0.939	1.23	1.54	1.85	2.49
90.0	0.0211	0.106	0.220	0.349	0.630	0.931	1.09	1.40	1.73	2.06	2.73
75.0	0.0575	0.192	0.345	0.507	0.844	1.19	1.37	1.72	2.08	2.45	3.18
50.0	0.139	0.336	0.535	0.734	1.13	1.53	1.73	2.13	2.53	2.93	3.73
25.0	0.277	0.539	0.784	1.02	1.48	1.94	2.16	2.60	3.04	3.48	4.35
10.0	0.461	0.778	1.06	1.34	1.85	2.35	2.60	3.08	3.56	4.03	4.95
5.0	0.599	0.949	1.26	1.55	2.10	2.63	2.89	3.39	3.89	4.38	5.34
1.0	0.921	1.33	1.68	2.01	2.62	3.20	3.48	4.03	4.56	5.09	6.12
0.040	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5	3.0	3.5	4.0

Acceptable Quality Levels (tightened inspection)

TABLE X-N-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: N

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																	Higher than 2.5
		Less than 0.025	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	Higher than 2.5					
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
Single	500	▽	0 1			1 2 2 3 3 4 5 6 7 8 9 10 11 12 13 14 15 18 19 21 22										△			
Double	315	▽	•	Use code Letter M	Use code Letter Q	0 2 0 3 1 4 2 5 3 7 3 7 5 9 6 10 7 11 9 14 11 16										△			
	630					1 2 3 4 4 5 6 7 8 9 11 12 12 13 15 16 18 19 23 24 26 27													
Multiple	125	▽	•			0 2 0 3 0 3 1 5 1 6 2 7 3 8 3 9 4 10 6 12 7 14										△			
	250					0 2 0 3 1 4 2 6 3 8 4 9 6 10 7 12 8 13 11 17 13 19													
	375					0 3 1 4 2 5 3 7 5 10 6 11 8 13 10 15 12 17 16 22 19 25													
	500					1 3 2 4 3 6 5 8 7 11 9 12 11 15 14 17 20 21 23 27 29 31 33													
	625					1 3 3 5 4 6 7 9 10 12 12 14 14 17 18 20 21 23 27 29 31 33													
	750					2 3 4 5 6 7 9 10 13 14 14 15 18 19 21 22 25 26 32 33 37 38													
	875																		
		Less than 0.040	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	Higher than 2.5						

Acceptable Quality Levels (tightened inspection)

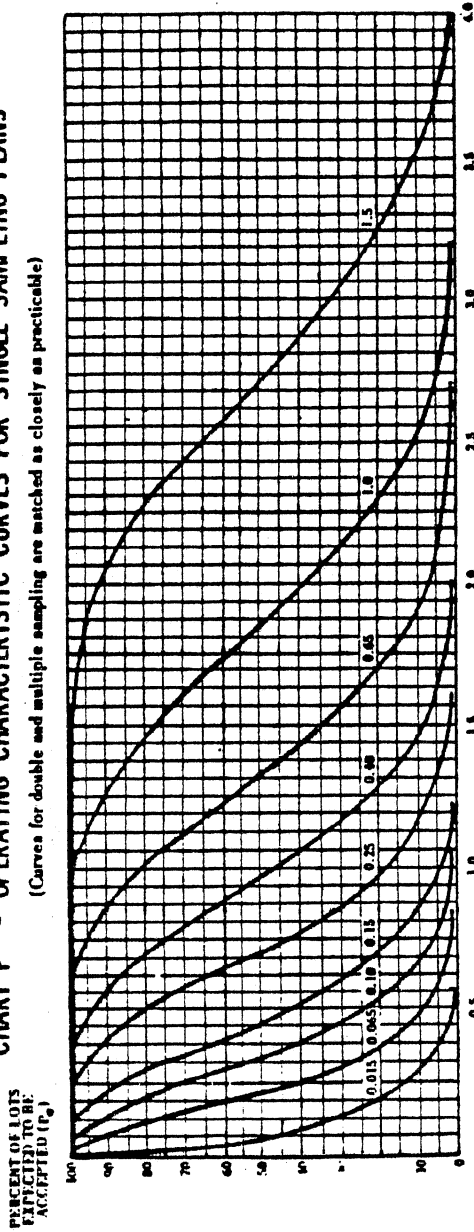
△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
Ac = Acceptance number
Re = Rejection number
• = Use single sampling plan above (or alternatively use code letter R)
• = Acceptance not permitted at this sample size.

N

TABLE X-P—Tables for sample size code letter: P

CHART P - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)



QUALITY OF SUBMITTED LOTS (p in percent defective for AQL's < 10 ; in defects per hundred units for AQL's > 10)

Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-P-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P_a	Acceptable Quality Levels (normal inspection)										
	0.015	0.045	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5
	p (in percent defective or defects per hundred units)										
99.0	0.00126	0.0186	0.0545	0.103	0.223	0.363	0.438	0.596	0.762	0.935	1.29
95.0	0.00641	0.0444	0.102	0.171	0.327	0.498	0.587	0.771	0.961	1.16	1.56
90.0	0.0132	0.0665	0.138	0.218	0.394	0.582	0.679	0.878	1.08	1.29	1.71
75.0	0.0360	0.120	0.216	0.317	0.527	0.745	0.855	1.08	1.30	1.53	1.99
50.0	0.0866	0.210	0.334	0.459	0.709	0.959	1.08	1.33	1.58	1.83	2.33
25.0	0.173	0.337	0.490	0.639	0.928	1.21	1.35	1.63	1.90	2.17	2.72
10.0	0.298	0.486	0.665	0.835	1.16	1.47	1.62	1.93	2.22	2.52	3.09
5.0	0.374	0.593	0.787	0.969	1.31	1.64	1.80	2.12	2.43	2.74	3.34
1.0	0.576	0.830	1.05	1.26	1.64	2.00	2.18	2.52	2.85	3.18	3.82
0.025	0.10	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5	3.0
Acceptable Quality Levels (tightened inspection)											
99.0	0.00126	0.0186	0.0545	0.103	0.223	0.363	0.438	0.596	0.762	0.935	1.29
95.0	0.00641	0.0444	0.102	0.171	0.327	0.498	0.587	0.771	0.961	1.16	1.56
90.0	0.0132	0.0665	0.138	0.218	0.394	0.582	0.679	0.878	1.08	1.29	1.71
75.0	0.0360	0.120	0.216	0.317	0.527	0.745	0.855	1.08	1.30	1.53	1.99
50.0	0.0866	0.210	0.334	0.459	0.709	0.959	1.08	1.33	1.58	1.83	2.33
25.0	0.173	0.337	0.490	0.639	0.928	1.21	1.35	1.63	1.90	2.17	2.72
10.0	0.298	0.486	0.665	0.835	1.16	1.47	1.62	1.93	2.22	2.52	3.09
5.0	0.374	0.593	0.787	0.969	1.31	1.64	1.80	2.12	2.43	2.74	3.34
1.0	0.576	0.830	1.05	1.26	1.64	2.00	2.18	2.52	2.85	3.18	3.82
0.025	0.10	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5	3.0

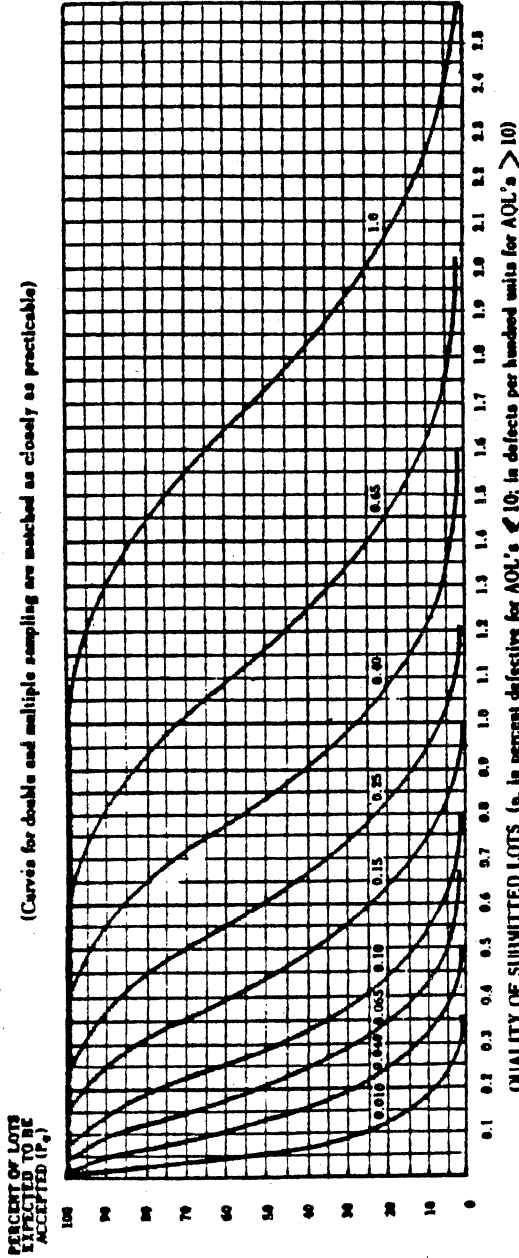
Note: All values given in above based on Poisson distribution as an approximation to the Binomial.

- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number.
- Re = Rejection number.
- = Use single sampling plan above.
- = Acceptance not permitted at this sample size.

TABLE X-Q—Tables for sample size code letter: Q

CHART Q - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)



Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-Q-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _a	Acceptable Quality Levels (normal inspection)										
	0.010	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.0	1.0
p (in percent defective or defects per hundred units)											
99.0	0.000004	0.0119	0.0349	0.0659	0.143	0.232	0.281	0.382	0.488	0.598	0.828
95.0	0.00410	0.0284	0.0654	0.109	0.209	0.318	0.376	0.494	0.615	0.740	0.995
90.0	0.00843	0.0425	0.0982	0.140	0.252	0.372	0.435	0.562	0.692	0.824	1.09
75.0	0.0230	0.0769	0.138	0.203	0.338	0.476	0.547	0.690	0.834	0.979	1.27
50.0	0.0655	0.134	0.214	0.294	0.454	0.614	0.694	0.853	1.01	1.17	1.49
25.0	0.111	0.215	0.314	0.409	0.594	0.775	0.864	1.04	1.22	1.39	1.74
10.0	0.184	0.311	0.426	0.534	0.742	0.942	1.04	1.23	1.42	1.61	1.98
5.0	0.240	0.380	0.504	0.620	0.841	1.05	1.15	1.36	1.56	1.75	2.14
1.0	0.368	0.531	0.672	0.804	1.05	1.28	1.39	1.61	1.83	2.04	2.45
0.315	0.065	0.10	0.10	0.15	0.25	0.40	0.65	1.0	1.0	1.0	1.0
Acceptable Quality Levels (tightened inspection)											

Note: All values given in above table based on distribution as an approximation to the Binomial

TABLE X-Q-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: Q

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																Cumulative sample size											
		X	0.010		0.015		X	0.025		0.040		0.065		0.10		0.15			0.25		X	0.40		0.65		1.0		Higher than 1.0	
			Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re		Ac	Re	Ac	Re	Ac	Re		Ac
Single	1250																												Δ
		0	1																										
		Use																											
Double	800 1600																												Δ
		•																											
		Letter																											
Multiple	315 630 945 1260 1575 1890 2205																												Δ
		•																											
0.010		0.015	X	0.025	0.040	0.065	0.10	0.15	0.25	X	0.40	X	0.65	X	1.0	X	Higher than 1.0												
Ac		Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re											

Acceptable Quality Levels (tightened inspection)

Acceptable Quality Levels (tightened inspection)

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above.

• = Acceptance not permitted at this sample size.

Q

TABLE X-R—Tables for sample size code letter: R

CHART R - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

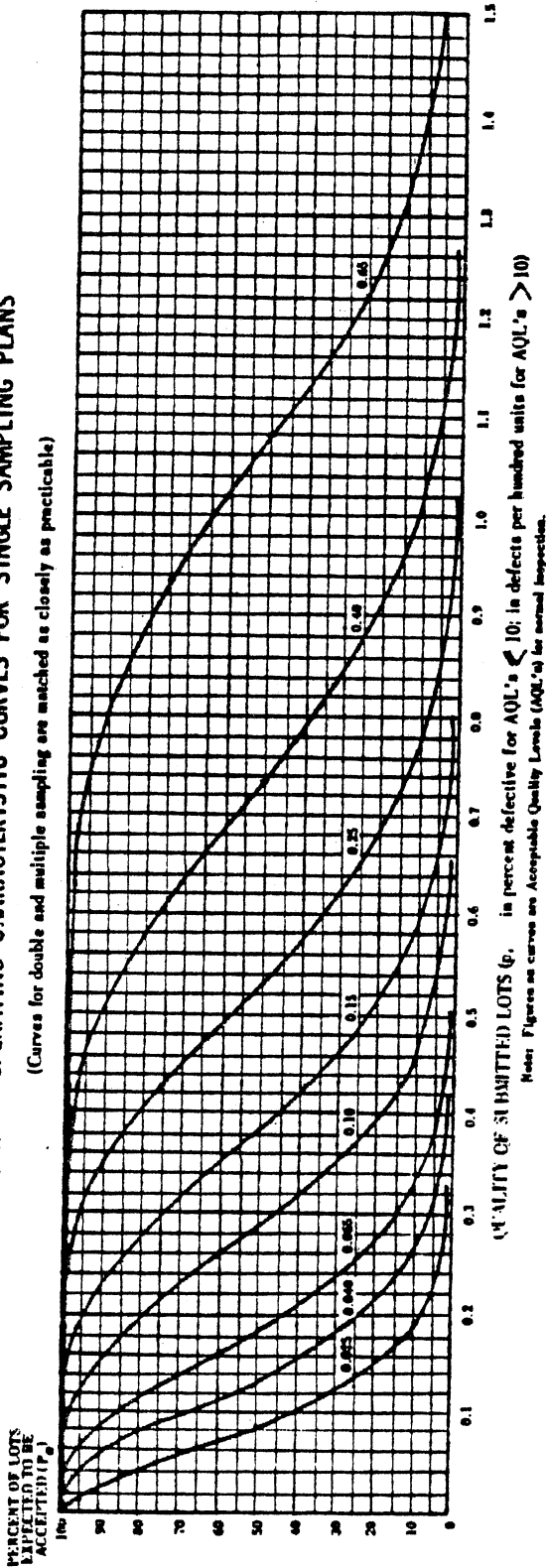


TABLE X-R-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _a	Acceptable Quality Levels (normal inspection)									
	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	0.65	0.65
p (in percent defective or defects per hundred units)										
99.0	0.00743	0.0219	0.0412	0.0892	0.145	0.175	0.239	0.305	0.374	0.517
95.0	0.0178	0.0409	0.0683	0.131	0.199	0.235	0.309	0.384	0.462	0.622
90.0	0.0266	0.0551	0.0872	0.158	0.233	0.272	0.351	0.432	0.515	0.684
75.0	0.0481	0.0864	0.127	0.211	0.296	0.342	0.431	0.521	0.612	0.795
50.0	0.0839	0.134	0.181	0.284	0.343	0.433	0.533	0.633	0.733	0.934
25.0	0.115	0.196	0.255	0.371	0.484	0.540	0.651	0.761	0.870	1.08
10.0	0.194	0.266	0.334	0.464	0.589	0.650	0.770	0.889	1.01	1.25
5.0	0.237	0.315	0.388	0.526	0.657	0.722	0.848	0.972	1.09	1.41
1.0	0.332	0.420	0.502	0.655	0.800	0.870	1.02	1.14	1.27	1.51
0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.02	1.53	2.14	3.08
Acceptable Quality Levels (tightened inspection)										
99.0	0.00743	0.0219	0.0412	0.0892	0.145	0.175	0.239	0.305	0.374	0.517
95.0	0.0178	0.0409	0.0683	0.131	0.199	0.235	0.309	0.384	0.462	0.622
90.0	0.0266	0.0551	0.0872	0.158	0.233	0.272	0.351	0.432	0.515	0.684
75.0	0.0481	0.0864	0.127	0.211	0.296	0.342	0.431	0.521	0.612	0.795
50.0	0.0839	0.134	0.181	0.284	0.343	0.433	0.533	0.633	0.733	0.934
25.0	0.115	0.196	0.255	0.371	0.484	0.540	0.651	0.761	0.870	1.08
10.0	0.194	0.266	0.334	0.464	0.589	0.650	0.770	0.889	1.01	1.25
5.0	0.237	0.315	0.388	0.526	0.657	0.722	0.848	0.972	1.09	1.41
1.0	0.332	0.420	0.502	0.655	0.800	0.870	1.02	1.14	1.27	1.51
0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.02	1.53	2.14	3.08

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial.

TABLE X-R-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: R

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																Cumulative sample size																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																													
		X	0.010		0.015		X	0.025		0.040		0.065		0.10		0.15			X	0.25		0.40		0.65		Higher than 0.65																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					
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△ Use next preceding sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number.

Re = Rejection number.

• Use single sampling plan above.

• Acceptance not permitted at this sample size.

R

TABLE X-S—Tables for sample size code letter: S

Type of sampling plan	Cumulative sample size	Acceptable Quality Level (normal inspection)	
		Ac	Re
Single	3150	1	2
Double	2000	0	2
	4000	1	2
Multiple	800	#	2
	1600	#	2
	2400	0	2
	3200	0	3
	4000	1	3
	4800	1	3
	5600	2	3
		0.025	
		Acceptable Quality Level (tightened inspection)	

Ac = Acceptance number

Re = Rejection number

= Acceptance not permitted at this sample size.

6. NOTES

6.1 Intended Use. Sampling procedures and tables for inspection by attributes are intended to be used in the acquisition of Defense material.

6.2 Subject Term (Key Word) Listing.

Acceptable Quality Level (AQL)

Average Outgoing Quality (AOQ)

Defect

Defective

Lot or Batch

Process Average

Sample

Sampling Plan

Unit of Product

6.3 Changes from Previous Issue. Vertical lines or asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

CONCLUDING MATERIAL

Custodians:

Army - AR
Navy - OS
Air Force - 23

Preparing Activity:

Army - AR

Review Activities:

Army - MI, EA, TE, AV, ER
Navy - AS, EC, MC, OM, SA,
SH, TD, YD
DLA - ES, GS, SS
OSD - IP, SO

(Project QCIC-0085)

User Activities:

Army - ME
DLA - ES, SS